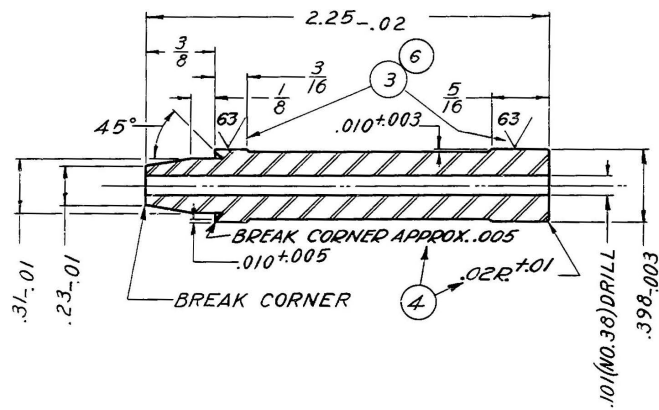


HEAT TREATMENT & PROTECTIVE FINISH  
PACK HARDEN .035 ± .005 DEEP

PROT. FIN. TYPE II CLASS A USA 57-0-2

(2) (6)



NOTICE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

ACTUATOR (B147486-4 6147486)  
STEEL FS 1022  
FED SPEC QQ-S-633  
FINISH 125/EXCEPT AS NOTED

(1) (2) (4) (5)

TOLERANCE ± .01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

DWG B7266102 APPLIES

PHYSICAL PROPERTIES		JUNE 5, 1940	
		REVISIONS	
Y.P.		1 11-22-40	6 2-18-52
T.S.		2 10-16-41	7 9 JUNE 55
EL. 2		3 4-25-42	
RED.		4 6-22-44	
BR.		5 7-28-49	
ROCK.		DELETED 11-15-50	
SCL.			
HARDNESS	FILE HARD	DRG. PERTAINS TO	
		FT265703	30 BAR-M/1918-A2

(6)

(7)

SYMBOL

DO NOT INSCRIBE PART NO.  
OFFICER IN CHARGE  
CHECKER  
SUBMITTED  
MAJ. ORD. DEPT. U.S.A.  
APPROVED BY ORDER OF THE  
CHIEF OF ORDNANCE  
L. COL. G. M. U.S.A.  
ORDNANCE DEPT. U.S.A.

SCALE 2/7  
B6147486  
B147486

SUPERSEDES B147486

B6147486

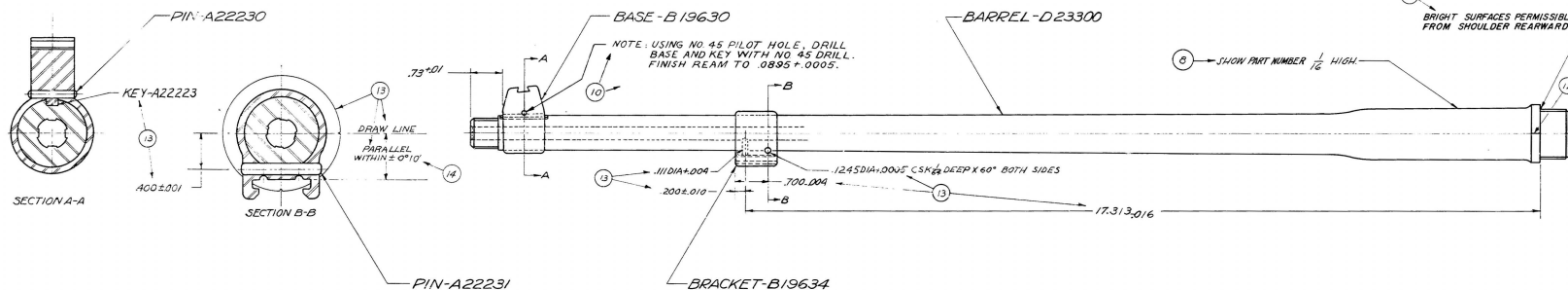


# HEAT TREATMENT & FINAL FINISH

PROT. FINISH TYPE I, SPEC. MIL-C-16232  
EXCEPT BORE AND CHAMBER

9 11 16

6 12



## LIST OF COMPONENTS

1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	QUANTITY REQUIRED
1	D8769	BARREL, ASSEMBLY	(1)
2		COMPOSED OF:-	
3	D23300	1- BARREL	*
4	B19630	1- BASE, FRONT SIGHT	
5	B19634	1- BRACKET, GAS CYLINDER TUBE	*
6	A22223	1- KEY, FRONT SIGHT	
7	A22230	1- PIN, FRONT SIGHT KEY	
8	A22231	1- PIN, GAS CYLINDER TUBE BRACKET	

\* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.

SUPERSEDES OLD TRACING D8769 UNDER REVISION DATE OF JUNE 1, 1936.

BARREL, ASSEMBLY D8769-6 6508769

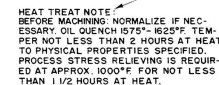
NOTE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

0 1 2 3 4 5 6 7 8 9 10 11 INCHES

0 1 2 3 4 5 INCHES

10/10-4-51	1/19-1-53				
11/7-16-52	1919 JUNE 55				
12/10-1-52	16, 18 AUG 55				
13/2-12-53					
MAY 1, 1929		CLASS	DIVISION	DRAWING FILE	
REVISIONS					
1	16-1-36	14-19-43			
2	4-15-38	14-15-44			
3	6-1-39	12-28-45			
4	8-27-40	12-28-45			
5	16-25-40	16-9-51			
D8769 PERTAINS TO		OFFSMAN	TRACER	LDG. OFFSMAN	
51-19-30 BAR-MIG		E.L.V.	W.C.A.	U.P.O.	
		CHECKER	1/10	1/10	
TRANSFER 30 BAR-MIG		SUBMITTER			
		EXAMINER			
		LT. COL. ORD. DEPT. U.S.A.			
		APPROVED BY ORDER OF THE CHIEF OF ORDNANCE			
		LT. COL. ORD. DEPT. U.S.A.			
		ORDNANCE DEPT. U.S.A.			

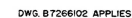
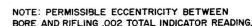
SUPERSEDES D8769



BARREL (6523300

OR

FINISH 125/ EXCEPT AS NOTED



SEA TREATMENT & PROTECTIVE FINISH				CLASS		DIVISION		DRAWING		
SEE HEAT TREAT NOTE										
FOR PROT. FINISH SEE ASSEMBLY DWG.										
PHYSICAL PROPERTIES					DRAWING PARTS TO					
MATERIAL					MATERIAL		MATERIAL		MATERIAL	
277-321					0606709 BOBAR MIRAZ					
INITIAL DATE OF DRAWING: MAY 1, 1929										
REVISIONS:										
26.6-17-52 98339 GWS										
27.7-16-52 18041 CLR										
28.8-12-52 18092 CLR										
29.10-1-52 18260 CLR										
WEIGHT					DO NOT					APPLY PART NO.
					+000					(See Symbol)
SCALE										
TOLERANCES ON DIMENSIONS:					1/16" ± .001					
					1/32" ± .001					
					1/64" ± .001					
					1/128" ± .001					
					1/256" ± .001					
					1/512" ± .001					
					1/1024" ± .001					
					1/2048" ± .001					
					1/4096" ± .001					
					1/8192" ± .001					
					1/16384" ± .001					
					1/32768" ± .001					
					1/65536" ± .001					
					1/131072" ± .001					
					1/262144" ± .001					
					1/524288" ± .001					
					1/1048576" ± .001					
					1/2097152" ± .001					
					1/4194304" ± .001					
					1/8388608" ± .001					
					1/16777216" ± .001					
					1/33554432" ± .001					
					1/67108864" ± .001					
					1/134217728" ± .001					
					1/268435456" ± .001					
					1/536870912" ± .001					
					1/1073741824" ± .001					
					1/2147483648" ± .001					
					1/4294967296" ± .001					
					1/8589934592" ± .001					
					1/17179869184" ± .001					
					1/34359738368" ± .001					
					1/68719476736" ± .001					
					1/137438953472" ± .001					
					1/274877906944" ± .001					
					1/549755813888" ± .001					
					1/1099511627776" ± .001					
					1/2199023255552" ± .001					
					1/4398046511104" ± .001					
					1/8796093022208" ± .001					
					1/17592186044416" ± .001					
					1/35184372088832" ± .001					
					1/70368744177664" ± .001					
					1/140737488355328" ± .001					
					1/281474976710656" ± .001					
					1/562949953421312" ± .001					
					1/1125899906842624" ± .001					
					1/2251799813685248" ± .001					
					1/4503599627370496" ± .001					
					1/9007199254740992" ± .001					
					1/18014398509481984" ± .001					
					1/36028797018963968" ± .001					
					1/72057594037927936" ± .001					
					1/144115188075855872" ± .001					
					1/288230376151711744" ± .001					
					1/576460752303423488" ± .001					
					1/1152921504606846976" ± .001					
					1/2305843009213693952" ± .001					
					1/4611686018427387904" ± .001					
					1/9223372036854775808" ± .001					
					1/18446744073709551616" ± .001					
					1/36893488147419103232" ± .001					
					1/73786976294838206464" ± .001					
					1/147573952589676412928" ± .001					
					1/295147905179352825856" ± .001					
					1/590295810358705651712" ± .001					
					1/1180591620717411303424" ± .001					
					1/2361183241434822606848" ± .001					
					1/4722366482869645213696" ± .001					
					1/9444732965739290427392" ± .001					
					1/18889465931478580854784" ± .001					
					1/37778931862957161709568" ± .001					
					1/75557863725914323419136" ± .001					
					1/151115727451828646838272" ± .001					
					1/302231454903657293676544" ± .001					
					1/604462909807314587353088" ± .001					
					1/1208925819614629174706176" ± .001					
					1/2417851639229258349412352" ± .001					
					1/4835703278458516698824704" ± .001					
					1/9671406556917033397649408" ± .001					
					1/19342813113834066795298816" ± .001					
					1/38685626227668133590597632" ± .001					
					1/77371252455336267181195264" ± .001					
					1/154742504910672534362390528" ± .001					
					1/309485009821345068724781056" ± .001					
					1/618970019642690137449562112" ± .001					
					1/1237940039285380274899124224" ± .001					
					1/2475880078570760549798248448" ± .001					
					1/4951760157141521099596496896" ± .001					
					1/9903520314283042199192993792" ± .001					
					1/19807040628566084398385987584" ± .001					
					1/39614081257132168796771975168" ± .001					
					1/79228162514264337593543950336" ± .001					
					1/158456325028528675187087900672" ± .001					
					1/316912650057057350374175801344" ± .001					
					1/633825300114114700748351602688" ± .001					
					1/1267650600228229401496703205376" ± .001					
					1/2535301200456458802993406410752" ± .001					
					1/5070602400912917605986812821504" ± .001					
					1/10141204801825835211973625643008" ± .001					
					1/20282409603651670423947251286016" ± .001					
					1/40564819207303340847894502572032" ± .001					
					1/81129638414606681695789005144064" ± .001					
					1/162259276829213363391578010288128" ± .001					
					1/324518553658426726783156020576256" ± .001					
					1/649037107316853453566312041152512" ± .001					
					1/1298074214633706907132624082305024" ± .001					
					1/2596148429267413814265248164610048" ± .001					
					1/5192296858534827628530496329220096" ± .001					
					1/10384593717069655257060992658440192" ± .001					
					1/20769187434139310514121985316880384" ± .001					
					1/41538374868278621028243970633760768" ± .001					
					1/83076749736557242056487940633760768" ± .001					
					1/16615349947311448411297588127321536" ± .001					
					1/33230699894622896822595176254643072" ± .001					
					1/66461399789245793645190352509286144" ± .001					
					1/132922799578491587290380705018572288" ± .001					
					1/265845599156983174580761410037144576" ± .001					
					1/531691198313966349161522820074289152" ± .001					
					1/1063382396627932698323045640148578304" ± .001					
					1/2126764793255865396646091280297156608" ± .001					
					1/4253529586511730793292182560594313216" ± .001					
					1/8507059173023461586584365121188626432" ± .001					
					1/17014118346046923173168730242377252864" ± .001					
					1/340282366920938463463374604847545056" ± .001					
					1/680564733841876926926749209695090112" ± .001					
					1/1361129467683753853853498419390180224" ± .001					
					1/2722258935367507707706996838780360448" ± .001					
					1/5444517870735015415413993677560720896" ± .001					
					1/10889035741470030830827987355121441792" ± .001					
					1/21778071482940061661655974710242883584" ± .001					
					1/43556142965880123323311949420485767168" ± .001					
					1/87112285931760246646623898840971534336" ± .001					
					1/17422457186352049329324779768193068672" ± .001					
					1/34844914372704098658649559536386137344" ± .001					
					1/69689828745408197317299119072772274688" ± .001					
					1/139379657490816394634598238145544549376" ± .001					
					1/278759314981632789269196476291089098752" ± .001					
					1/557518629963265578538392952582178197504" ± .001					
					1/1115037259926531157076785905164356395008" ± .001					
					1/2230074519853062314153571810328712790016" ± .001					
					1/4460149039706124628307143620657425580032" ± .001					
					1/8920298079412249256614287241314851160064" ± .001					
					1/17840596158824498513228574482629702300128" ± .001					
					1/35681192317648997026457148965259404600256" ± .001					
					1/71362384635297994052914297930518809200512" ± .001					
					1/142724769270595988105828595861037618401024" ± .001					
					1/285449538541191976211657191722075236802048" ± .001					
					1/570899077082383952423314383444150473604096" ± .001					
					1/1141798154164767904846628766888300947208192" ± .001					
					1/2283596308329535809693257533776601894416384" ± .001					
					1/4567192616659071619386515067553203788832768" ± .001					
					1/9134385233318143238773030135106407577665536" ± .001					
					1/18268770466636286477546060270212815155331104" ± .001					
					1/3653754093327257295509212054042563031066208" ± .001					
					1/7307508186654514591018424108085126062132416" ± .001					
					1/14615016373309029182036848216170241224266432" ± .001					
					1/29230032746618058364073696432340482448532864" ± .001					
					1/58460065493236116728147392864680964897065728" ± .001					
					1/116920130986472233456294785729361929794131552" ± .001					
					1/233840261972944466912589571458723859588263104" ± .001					
					1/467680523945888933825179142917447719176526208" ± .001					
					1/935361047891777867650358285834895438353052416" ± .001					
					1/1870722095783555735300716571669890876706104832" ± .001					
					1/3741444191567111470601433143339781753412209664" ± .001					
					1/7482888383134222941202866286679563506824419328" ± .001					
					1/14965776766268445884405732573359127013648838656" ± .001					
					1/29931553532536891768811465146718544027297677312" ± .001					
					1/59863107065073783537622930293437088054595354624" ± .001					
					1/119726214130147567075245860586874176109190709248" ± .001					
					1/239452428260295134150491721173748352218381418496" ± .001					
					1/478904856520590268300983442347496704436762836992" ± .001					
					1/957809713041180536601966884694993408873525673984" ± .001					
					1/1915619426082361073203933769389986817747051379968" ± .001					
					1/3831238852164722146407867538779973635494102759936" ± .001					
					1/7662477704329444292815735077559947270988205519872" ± .001					
					1/15324955408658888585631470155119894541976411039744" ± .001					
					1/30649910817317777171262940310239789083952822079488" ± .001					
					1/61299821634635554342525880620479578167905644158976" ± .001					
					1/122599643269271108685051761240959156335811288317952" ± .001					
					1/245199286538542217370103522481918312671622576635904" ± .001					
					1/490398573077084434740207044963836625343245153271808" ± .001					
					1/980797146154168869480414089927673250686490306543616" ± .001					
					1/196159429230833773896082817985534650137298061308736" ± .001					
					1/392318858461667547792165635971069300274596122617472" ± .001					
					1/784637716923335095584331271942138600549192245234944" ± .001					
					1/1569275433846670191168662543884277201098384490469888" ± .001					
					1/3138550867693340382337325087768554402196768980939776" ± .001					
					1/6277101735386680764674650175537108804393537961879552" ± .001					
					1/12554203470773361529349300351074217688787075923759104" ± .001					
					1/2510840694154672305869860070214843537757415184751808" ± .001					
					1/5021681388309344611739720140429687075514830369503616" ± .001					
					1/1004336277661868922347944028085937415102966073900736" ± .001					
					1/2008672555323737844695888056171874830205932147801472" ± .001					
					1/4017345110647475689391776112343749660411864295602944" ± .001					
					1/8034690221294951378783552224687499320823728591205888" ± .001					
					1/16069380442589902757567104449374996401647457182411776" ± .001					

SUPERSEDES D 6523300 W/C JUNE 17, 1952

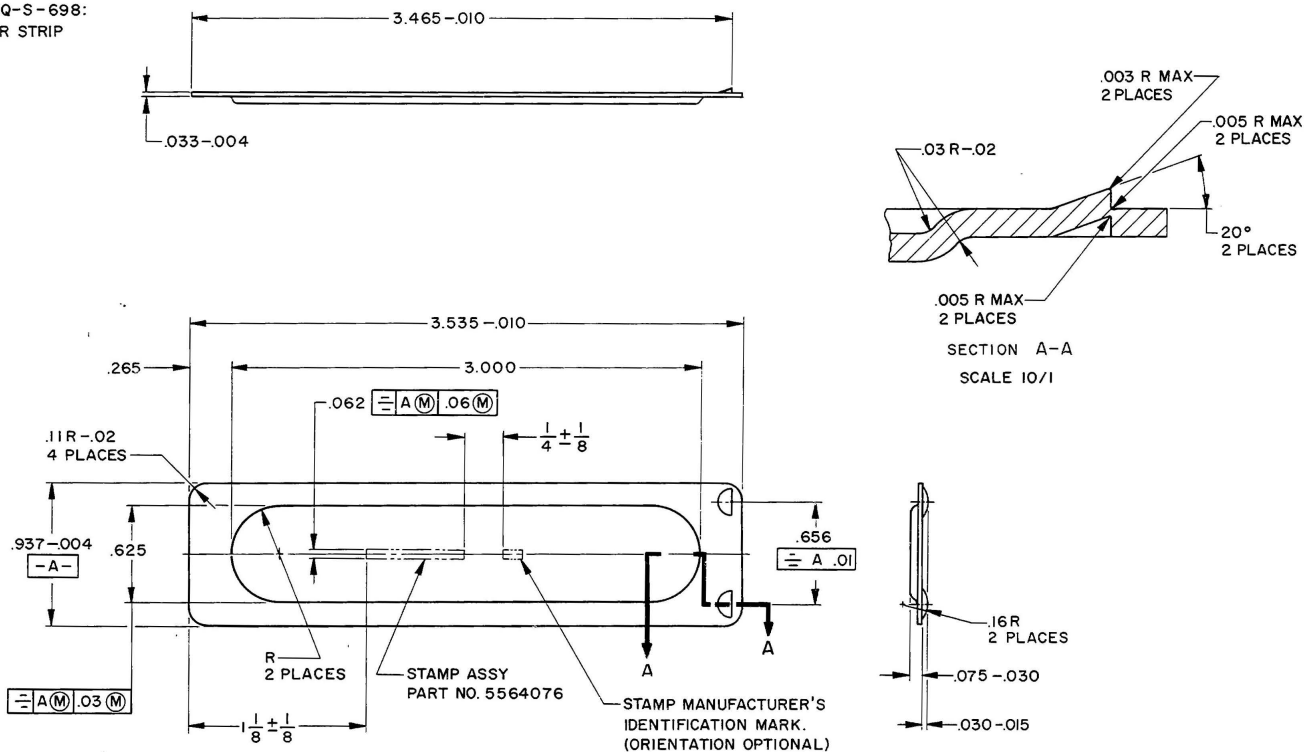
CE

NOTICE - WHEN GOVERNMENT DRAWINGS SPECIFICATIONS OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT HEREBY INCURS NO RESPONSIBILITY NOR ANY OBLIGATION WHATSOEVER, AND THE FACT THAT THE GOVERNMENT MAY HAVE FORMULATED, FURNISHED OR IN ANY WAY SUPPLIED SAID DRAWINGS, SPECIFICATIONS OR OTHER DATA IS NOT TO BE REGARDED BY IMPLICATION OR OTHERWISE AS IN ANY MANNER LICENSING THE HOLDER OR ANY OTHER PERSON OR CORPORATION OR CONVEYING ANY RIGHTS OR PERMISSION TO MANUFACTURE, USE OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE RELATED HERETO.

# NOTES:

1. FINISH 125 ✓
2. ALL CORNERS AND EDGES SHALL BE BROKEN .003+.012 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL: STEEL, FED. SPEC QQ-S-698: CARBON .24 PERCENT MAX, CR STRIP NO. 3 TEMPER.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
II		12 MAY 55	
A	REDRAWN & REVISED, WAS "B" SIZE. SEE EO SA 27570	7 JAN 65	<i>W. Cole</i>



PART NO. 6019631

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING		SPRINGFIELD ARMY U. S. ARMY WEAPONS COMMAND	
YP				1 MAY 29		SPRINGFIELD 1. MASS.	U. S. ARMY MATERIEL COMMAND
TS	C5564076	.30 BAR-	TOLERANCES ON DECIMALS ± .01	DRAFTSMAN	CHECKER	BASE, MAGAZINE	
EL 2		M1918 A2	FRACTIONS ± ANGLES ± 1°	ELJ	JJV		
RA	SEE ENGINEERING RECORDS		MATERIAL	TRACER	CHECKER		
BH	NEXT ASSY USED ON		SEE NOTE 3	ENGINEER	ENGINEER		
RH	APPLICATION		HEAT TREATMENT	SUBMITTED		CODE IDENT NO DWG SIZE	
	DO APPLY ASSY PART NO. PER MIL-STD-130		NONE			19205	C
	AS SPECIFIED		FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171	APPROVED		6019631	
				<i>R. S. Henry</i>		SCALE 2/1	UNIT WT SHEET 1 OF 1

8

7

6

5

4

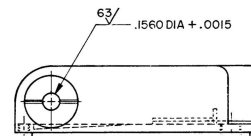
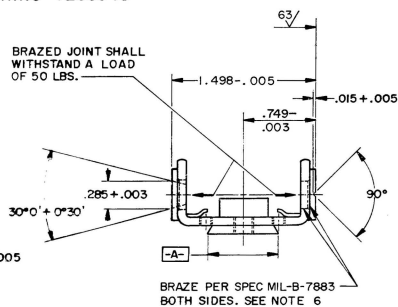
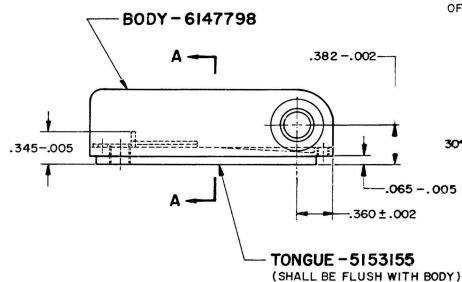
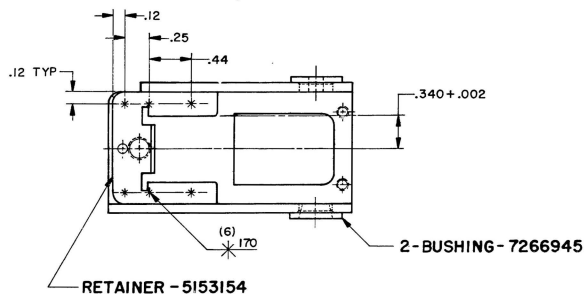
3

2

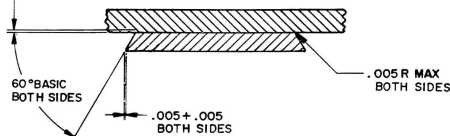
1

## NOTES:

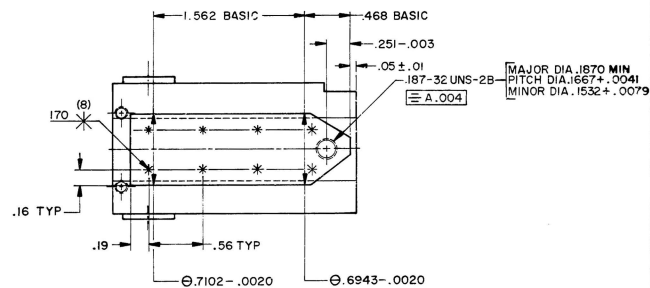
1.  $\sqrt{}$  ALL OVER EXCEPT AS NOTED.
2. HEAT TREATMENT:  
CARBURIZE AT 1575° TO 1600° F FROM .003 TO .005 CASE DEPTH. OIL QUENCH. TEMPER 30 MINUTES AT 350° F TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE ONLY EXCEPT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF CONTRACTING OFFICER.
3. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OF MIL-STD-171.
4. WELD IN ACCORDANCE WITH SPEC MIL-W-12332.
5. ALTERNATIVE METHOD:  
PROJECTION WELD. COPPER BRAZING MAY BE USED TO ASSIST IN MEETING LOAD REQUIREMENTS FOR EITHER METHOD OF WELDING.
6. BRAZING ALLOY, CLASS FS-BCu, SPEC QQ-B-650.
7. FILE HARD IN ACCORDANCE WITH SA-STD-104.
8.  $\varnothing$  DIMS. MEASURED TO SHARP CORNER.



.000 + .007 MISMATCH  
PERMISSIBLE AS A RESULT  
OF MACHINING DOVETAIL.  
BOTH SIDES



PARTIAL SECTION A-A  
SCALE 5/1



FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST - 7265564

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 9 NOV 42	
YP		TOLERANCES ON DECIMALS XXX.03		DRAFTSMAN D.H.	CHECKER F.B.
TS	D6535423	ANGLES ± 1°		DESIGNED BY	ENGINEER A.COLE
EL 2	30 BAR	MATERIAL		APPROVED BY	ENGINEER A.COLE
BA	M1918 A2	HEAT TREATMENT		SUBMITTED	
BH	SEE ENGINEERING RECORDS	SEE NOTE 2		APPROVED BY	
RH	APPLICATION	FINAL PROTECTIVE FINISH		SEE NOTE 3	
FILE HARD	APPLY PART NO.				
SEE NOTE 7					

PART NO. 7265564

DEPT OF THE ARMY  
ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201

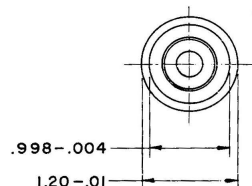
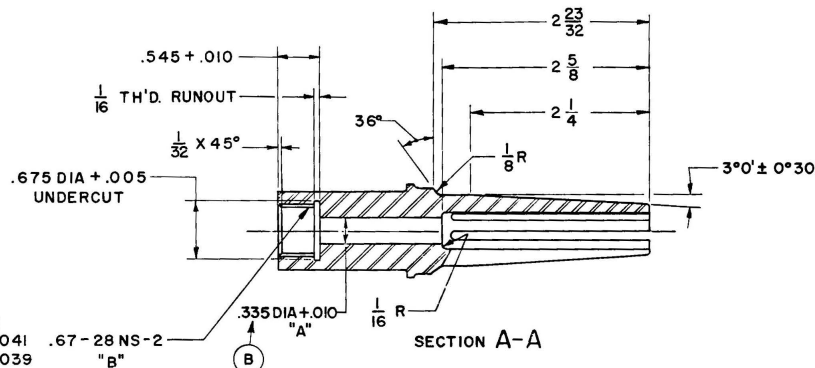
BASE, REAR SIGHT, ASSY

DWG SIZE CODE IDENT NO. 7265564  
F 19204

SCALE 2/1 UNIT WT. 1.8 SHEET 1 OF 1

**RESTRICTED**

MAJOR DIA .6700 MIN  
PITCH DIA .6468+.0041  
MINOR DIA .6313+.0039



DIAMETERS "A" AND "B" SHALL BE CONCENTRIC WITHIN .004 T.I.R.

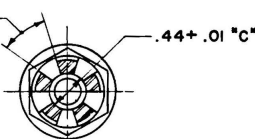
DIAMETERS "B" AND "C" SHALL BE CONCENTRIC WITHIN .010 T.I.R.

SURFACE "D" SHALL BE AT RIGHT ANGLE TO DIMENSION "B" WITHIN 0°10'

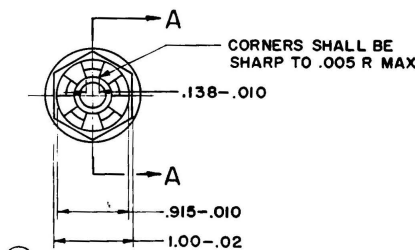
MATERIAL: STEEL, SPEC QQ-S-624, FS 4140

HEAT TREATMENT: HEAT TO 1525-1550°F.  
OIL QUENCH. TEMPER FOR 1 HOUR AT  
HEAT TO RH SPECIFIED

36°0' ± 0°30'  
(5 SPACES)



SECTION B-B



CORNERS SHALL BE SHARP TO .005 R MAX

RESTRICTED

**SECURITY INFORMATION**  
THIS DOCUMENT CONTAINS INFORMATION AFFECTING THE NATIONAL DEFENSE OF THE UNITED STATES WITHIN THE MEANING OF THE ESPIONAGE LAWS, TITLE 18, U.S.C., SECTION 793 AND 794. THE TRANSMISSION OR THE REVELATION OF ITS CONTENTS IN ANY MANNER TO ANY UNAUTHORIZED PERSON IS PROHIBITED BY LAW.

SYN	DESCRIPTION	DATE	APPROVAL
C	E.C.O. NO. 22810	5JUN55	
B	E.C.O. NO. 20359	27APR54	
A	CLASSIFICATION CANCELLED	5JAN54	
	BY AUTHORITY OCM 38028		
	SUPERSEDES B8147328 W/C	10-23-53	

NOTICE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

PHYSICAL PROPERTIES		DWG B 7266102 APPLIES		PART NO. C 7162966	
TP		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE	OCT 23, 1953
TS		TOLERANCES ON DECIMALS ± .01		DRAFTSMAN	WTS
EL 2		ANGLES ± 1°		CHECKER	WTS
RA		FRACTIONS ± 1/64		TRACER	WTS
BH		MATERIAL	SEE NOTE	ENGINEER	WTS
RH		HEAT TREATMENT	SEE NOTE	ENGINEER	WTS
		APPLICATION		SUBMITTED	
		DO NOT		APPROVED BY ORDER OF THE	
		APPLY PART NO.		CHIEF OF ORDNANCE	
		AS SPECIFIED		LT COL	
		FINAL PROTECTIVE FINISH			
		TYPE II CLASS A OR B			
		SPEC USA 57-0-2			

BEARING,  
FLASH HIDER  
AND BIPOD

FINISH 125 ALL OVER

SCALE 1/1 UNIT WT. 53

SPRINGFIELD ARMORY  
ORDNANCE CORP.  
DEPT OF THE ARMY

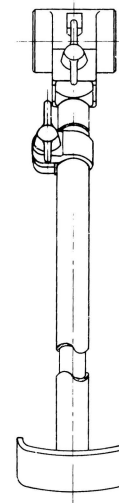
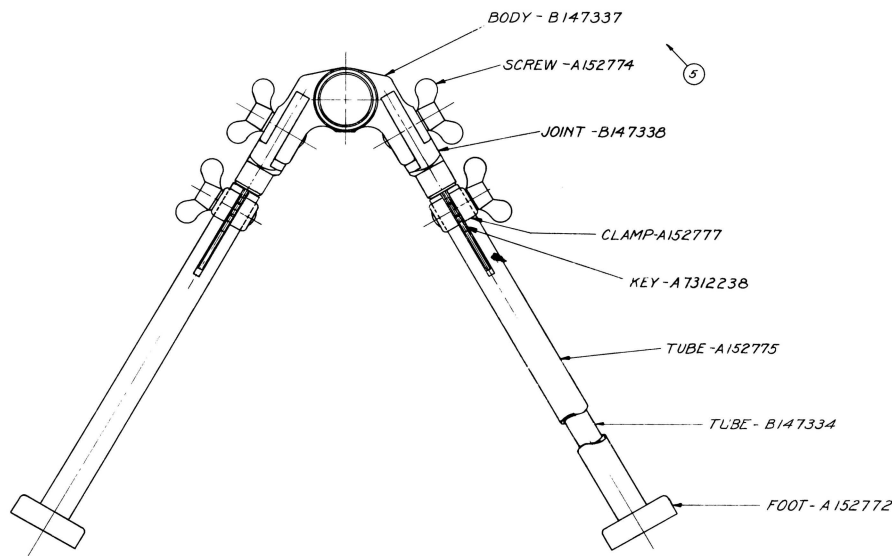
DWG  
SIZE  
7162966

SHEET 1 OF 1

**RESTRICTED**

C7162966

1. THIS DRAWING IS THE PROPERTY OF THE U.S. GOVERNMENT AND IS TO BE KEPT SEPARATELY FROM THE PARTS OF THE EQUIPMENT TO WHICH IT RELATES. IT IS TO BE RETURNED TO THE OFFICE OF ORDNANCE, U.S. ARMY, WASHINGTON, D.C. 20315, WHEN THE EQUIPMENT IS DISPOSED OF OR WHEN THE DRAWING IS NO LONGER REQUIRED FOR THE EQUIPMENT.



PHYSICAL PROPERTIES	
V.P.	
T.B.	
EL. 2	
RED.	
HT. T.	
BR.	
SCL.	
C.C.	

D7312239

# LIST OF COMPONENTS

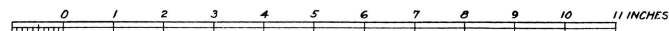
1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NO. REQUIRED PER UNIT ASSEMBLY
1	D7312239	BIPOD ASSEMBLY	1
2		COMPOSED OF:	
3	B147337	1-BODY, BIPOD	
4			
5	A7312238	2-KEY	
6	B7312235	2-LEG, BIPOD, ASSEMBLY	
7	B7312236	1-LEG, SLIDING, R.H. ASSEMBLY	
8	B7312237	1-LEG, SLIDING, L.H. ASSEMBLY	
9	A152774	4-SCREW, THUMB	
10			
11			
12			

BIPOD, ASSEMBLY (7312239)

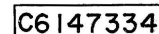
4 SPRINGFIELD ARMORY

JUNE 1, 1944		CLASS	DIVISION	DRAWING	FILE
REVISIONS					
1	7-13-44				
2	10-6-44				
3	1-11-45				
4	2-20-49				
5	1-16-50				
6	9 JUNE 55				
DTSMAN TRACER L.D.G. DTSMAN CHECKER CHECKER CHIEF DTSMAN SUBMITTED: <i>[Signature]</i> DRG. PERTAINS TO: <i>[Signature]</i> EXAMINED: <i>[Signature]</i> APPROVED BY ORDER OF THE CHIEF OF ORDNANCE LT COL ORD DEPT ORDNANCE DEPT., U. S. A.					

NOTICE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT



SUPERSEDES OLD TRACING D35424



REVISIONS	
DEPT OF THE ARMY U.S. ARMY WEAPONS' COMMAND ROCK ISLAND, ILL. 6120	
DWG SIZE C	6147334 SHEET      OF

CODE IDENT NO. 19204  
PART NO. 6147334

D	(3)SEE ERR HQR 20772	22SEP72	
C	(1) SEE EO HRD 82373	22JAN68	
B	(1-5) SEE EO RIA-14493	16NOV67	
A	REDRAWN AND REVISED	8 MAY 58	
	WAS "B" SIZE		
13		3MAY55	
SYM	DESCRIPTION	DATE	APPROVAL

TUBE,  
BIPOD LEG

DEPT OF THE ARMY  
U.S. ARMY  
WEAPONS COMMAND  
ROCK ISLAND, ILL. 6120

DWG SIZE	6147334		
C	SHEET	OF	

SCALE	1/4	UNIT WT.	26
-------	-----	----------	----

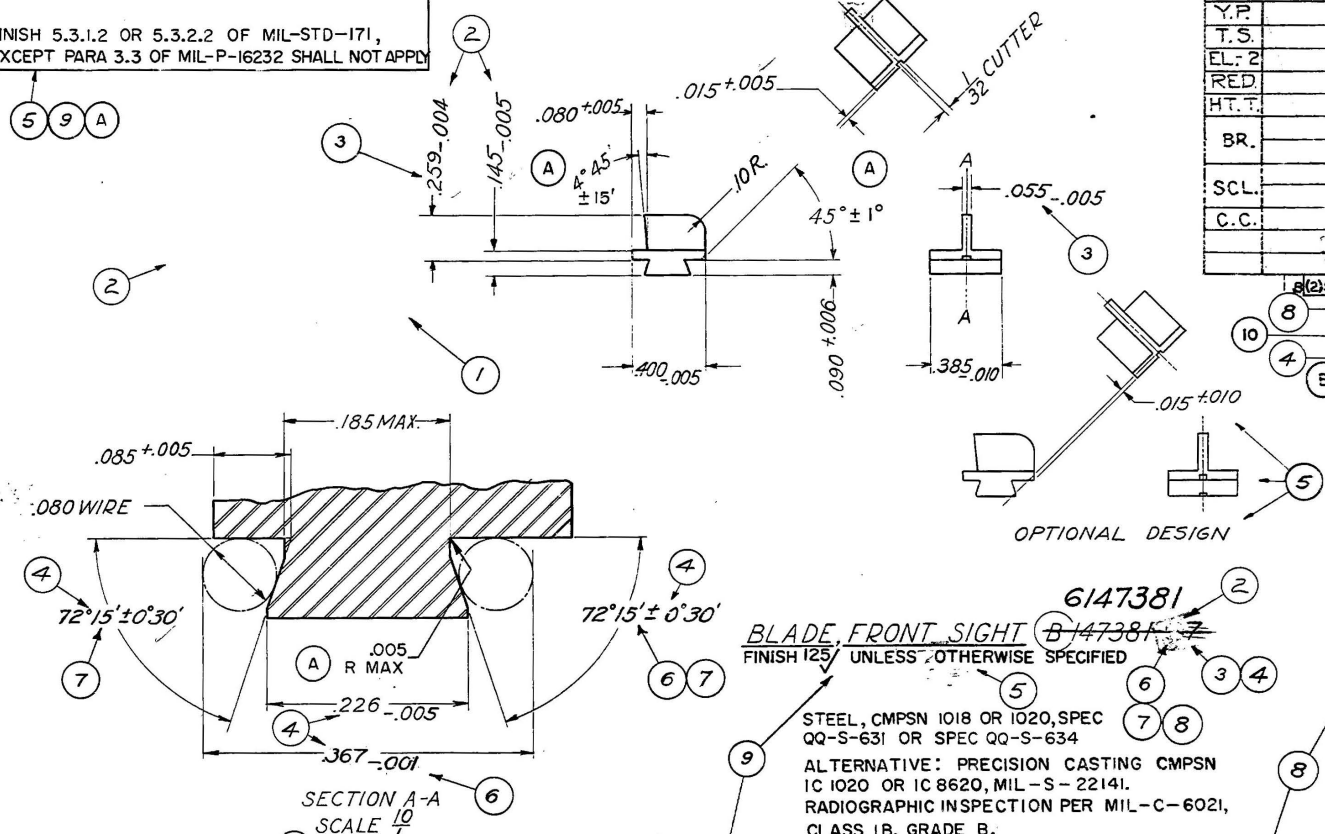
CE



# HEAT TREATMENT & PROTECTIVE FINISH

FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171,  
EXCEPT PARA 3.3 OF MIL-P-16232 SHALL NOT APPLY

NOTICE: THIS DRAWING SHALL NOT BE USED OR  
REPRODUCED EITHER WHOLLY OR IN PART EXCEPT  
WHEN AUTHORIZED IN CONNECTION WITH  
UNITED STATES GOVERNMENT PROCUREMENT.



MIL-W-13855 SHALL APPLY

TOLERANCE  $\pm .01$  ALLOWED ON ALL DIMEN-  
SIONS UNLESS OTHERWISE SPECIFIED.

BLADE, FRONT SIGHT  
FINISH 125 UNLESS OTHERWISE SPECIFIED

STEEL, CMPSN 1018 OR 1020, SPEC  
QQ-S-631 OR SPEC QQ-S-634  
ALTERNATIVE: PRECISION CASTING CMPSN  
1C 1020 OR 1C 8620, MIL-S-22141.  
RADIOGRAPHIC INSPECTION PER MIL-C-6021,  
CLASS 1B, GRADE B.

SCALE 2

CODE IDENT NO 19204

JUNE 1, 1933	
REVISIONS	
Y.P.	1' 10-28-40
T.S.	2' 2-15-41
EL. 2	3' 4-7-42
RED	4' 4-25-42
HT. T.	5' 12-10-42
	6' 7-30-43
BR.	7' 8-21-43
	8' 1-28-43
SCL.	9' 2-18-52
C.C.	10' 9 JUNE 55
A (1-6) 29 DEC 70	
SEE EO HRD 02135	
B (2) SEE ERR HOR 30776: 10 DEC 73	

DRG PERTAINS TO  
F7265703 30 BAR-M/9/842  
51-13 30 BAR-M/8

SYMBOL			
DO NOT INSCRIBE PART NO.			
OFFSMAN	TRACER	LOG	STAMP
E.G.R.	R.S.B.	L.S.P.	
CHECKER	DATE	CHKD	DATE
J.S.C.	1-1-43	J.H.A.	1-1-43
SUBMITTED BY			
Major Ord. Dept. USA			
APPROVED BY ORDER OF			
THE CHIEF OF ORDNANCE:			
Lt. Col. Ord. Dept. USA			
ORDNANCE DEPT USA			

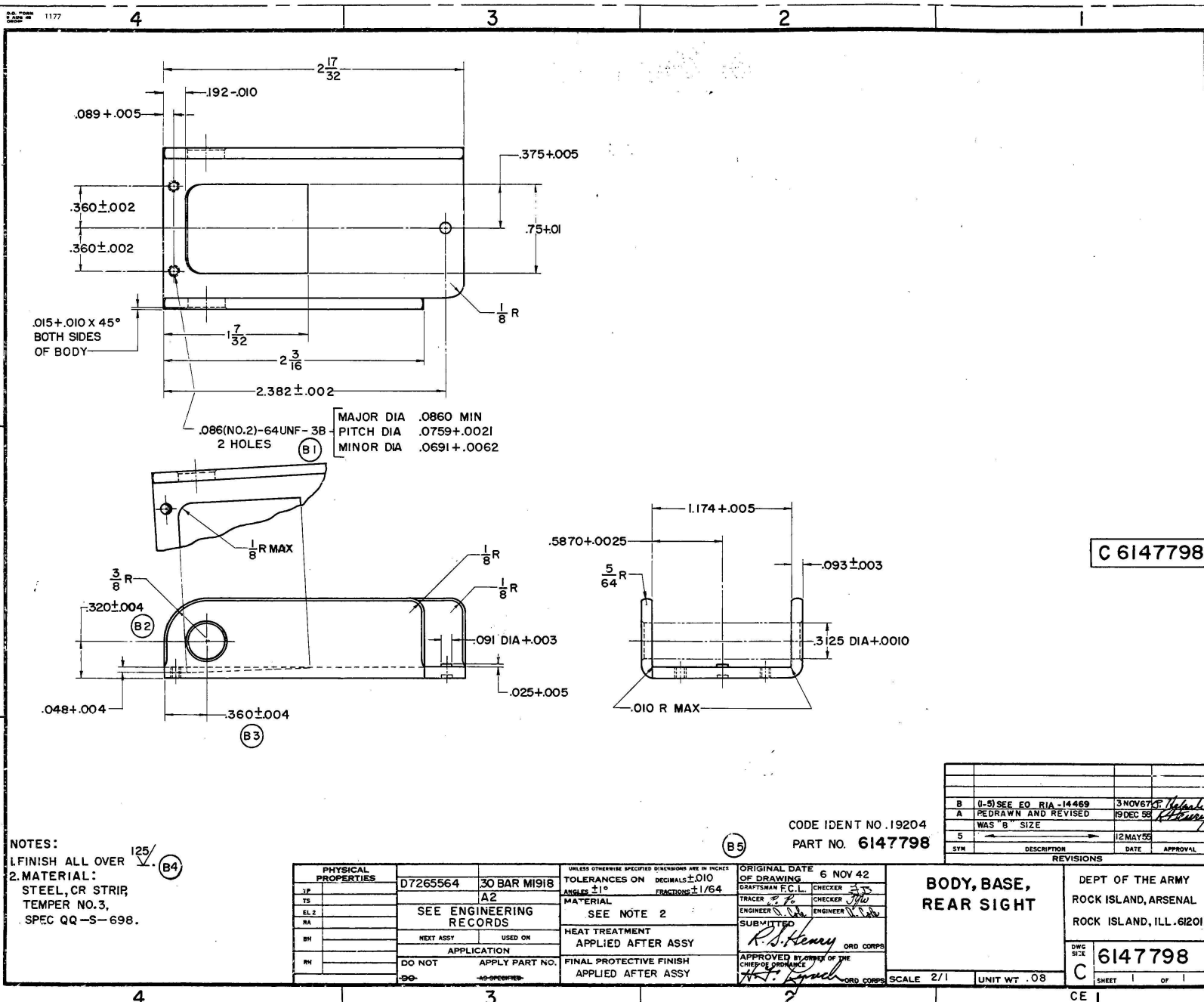
SUPERSEDES B147381

B6147381

C 6147798

C 6147798

A



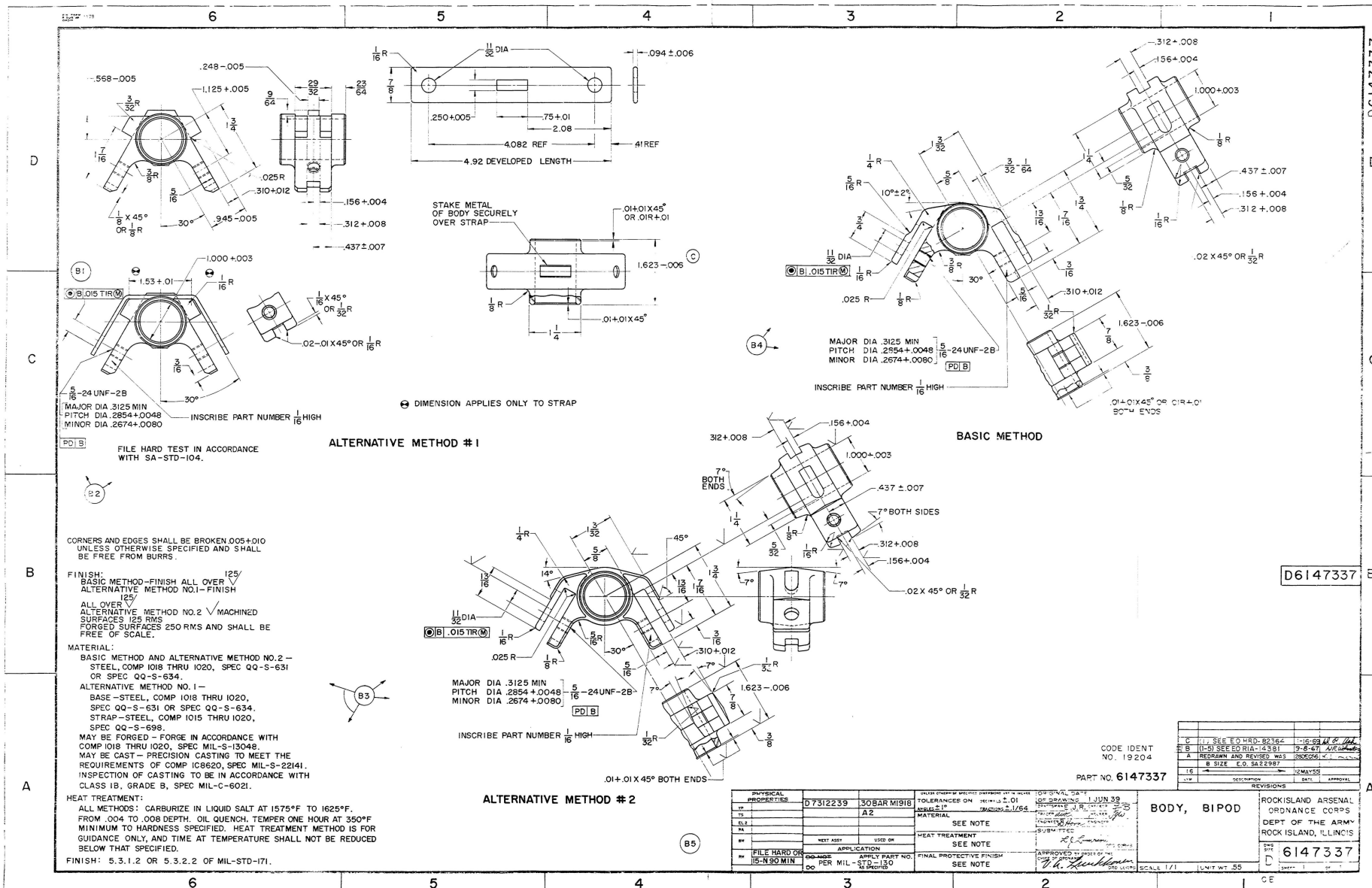
CODE IDENT NO. 19204  
PART NO. 6147798

BODY, BASE,  
REAR SIGHT

DEPT OF THE ARMY  
ROCK ISLAND, ARSENAL  
ROCK ISLAND, ILL. 61201

DWG  
SIZE  
C 6147798

CE



CODE IDENT  
NO. 19204

PART NO. 6147337

REVISIONS	DATE	APPROVAL
1	1-16-68	W. C. H. H.
2	1-16-68	W. C. H. H.
3	1-16-68	W. C. H. H.
4	1-16-68	W. C. H. H.
5	1-16-68	W. C. H. H.
6	1-16-68	W. C. H. H.
7	1-16-68	W. C. H. H.
8	1-16-68	W. C. H. H.
9	1-16-68	W. C. H. H.
10	1-16-68	W. C. H. H.
11	1-16-68	W. C. H. H.
12	1-16-68	W. C. H. H.
13	1-16-68	W. C. H. H.
14	1-16-68	W. C. H. H.
15	1-16-68	W. C. H. H.
16	1-16-68	W. C. H. H.
17	1-16-68	W. C. H. H.
18	1-16-68	W. C. H. H.
19	1-16-68	W. C. H. H.
20	1-16-68	W. C. H. H.
21	1-16-68	W. C. H. H.
22	1-16-68	W. C. H. H.
23	1-16-68	W. C. H. H.
24	1-16-68	W. C. H. H.
25	1-16-68	W. C. H. H.
26	1-16-68	W. C. H. H.
27	1-16-68	W. C. H. H.
28	1-16-68	W. C. H. H.
29	1-16-68	W. C. H. H.
30	1-16-68	W. C. H. H.
31	1-16-68	W. C. H. H.
32	1-16-68	W. C. H. H.
33	1-16-68	W. C. H. H.
34	1-16-68	W. C. H. H.
35	1-16-68	W. C. H. H.
36	1-16-68	W. C. H. H.
37	1-16-68	W. C. H. H.
38	1-16-68	W. C. H. H.
39	1-16-68	W. C. H. H.
40	1-16-68	W. C. H. H.
41	1-16-68	W. C. H. H.
42	1-16-68	W. C. H. H.
43	1-16-68	W. C. H. H.
44	1-16-68	W. C. H. H.
45	1-16-68	W. C. H. H.
46	1-16-68	W. C. H. H.
47	1-16-68	W. C. H. H.
48	1-16-68	W. C. H. H.
49	1-16-68	W. C. H. H.
50	1-16-68	W. C. H. H.
51	1-16-68	W. C. H. H.
52	1-16-68	W. C. H. H.
53	1-16-68	W. C. H. H.
54	1-16-68	W. C. H. H.
55	1-16-68	W. C. H. H.
56	1-16-68	W. C. H. H.
57	1-16-68	W. C. H. H.
58	1-16-68	W. C. H. H.
59	1-16-68	W. C. H. H.
60	1-16-68	W. C. H. H.
61	1-16-68	W. C. H. H.
62	1-16-68	W. C. H. H.
63	1-16-68	W. C. H. H.
64	1-16-68	W. C. H. H.
65	1-16-68	W. C. H. H.
66	1-16-68	W. C. H. H.
67	1-16-68	W. C. H. H.
68	1-16-68	W. C. H. H.
69	1-16-68	W. C. H. H.
70	1-16-68	W. C. H. H.
71	1-16-68	W. C. H. H.
72	1-16-68	W. C. H. H.
73	1-16-68	W. C. H. H.
74	1-16-68	W. C. H. H.
75	1-16-68	W. C. H. H.
76	1-16-68	W. C. H. H.
77	1-16-68	W. C. H. H.
78	1-16-68	W. C. H. H.
79	1-16-68	W. C. H. H.
80	1-16-68	W. C. H. H.
81	1-16-68	W. C. H. H.
82	1-16-68	W. C. H. H.
83	1-16-68	W. C. H. H.
84	1-16-68	W. C. H. H.
85	1-16-68	W. C. H. H.
86	1-16-68	W. C. H. H.
87	1-16-68	W. C. H. H.
88	1-16-68	W. C. H. H.
89	1-16-68	W. C. H. H.
90	1-16-68	W. C. H. H.
91	1-16-68	W. C. H. H.
92	1-16-68	W. C. H. H.
93	1-16-68	W. C. H. H.
94	1-16-68	W. C. H. H.
95	1-16-68	W. C. H. H.
96	1-16-68	W. C. H. H.
97	1-16-68	W. C. H. H.
98	1-16-68	W. C. H. H.
99	1-16-68	W. C. H. H.
100	1-16-68	W. C. H. H.

BODY, BIPOD

ROCKISLAND ARSENAL  
ORDNANCE CORPS  
DEPT OF THE ARMY  
ROCK ISLAND, ILLINOIS

6147337

C

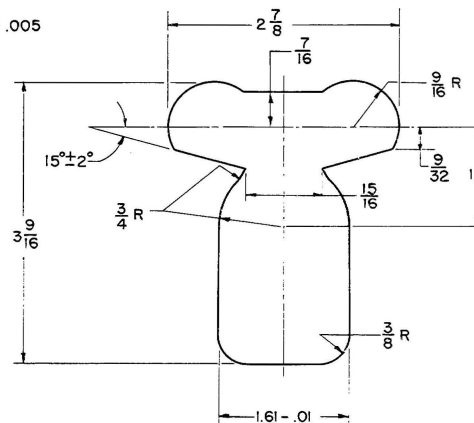
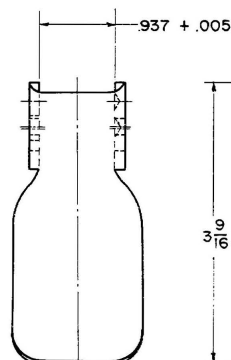
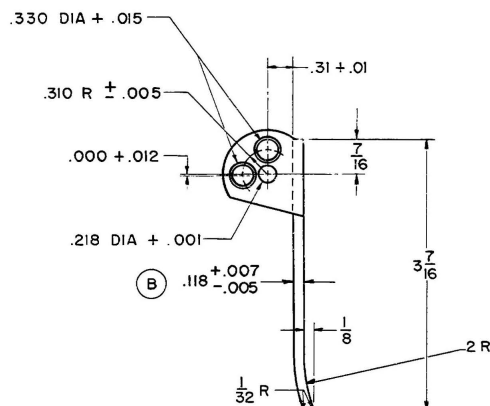
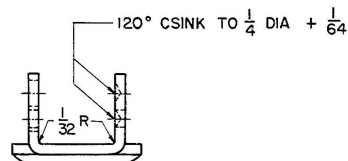
B

A

C 6147321

B

A



DEVELOPMENT OF BLANK

C6147321

## NOTES:

1. DWG B7266102 APPLIES.
2. FINISH 125/EXCEPT SHEARED AND STAMPED SURFACES 250/
3. HEAT TREATMENT: CARBURIZE AT 1575°F TO 1625°F. FROM .004 TO .008 DEPTH. QUENCH IN CIRCULATING OIL. TEMPER AT 375°F. FOR 30 MINUTES.
4. EDGES SHALL BE BROKEN .005 ± .010 UNLESS OTHERWISE SPECIFIED.

ORD PART NO. 6147321

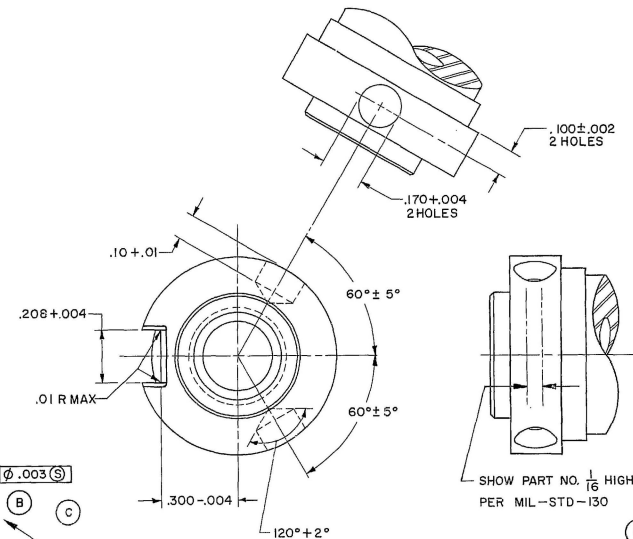
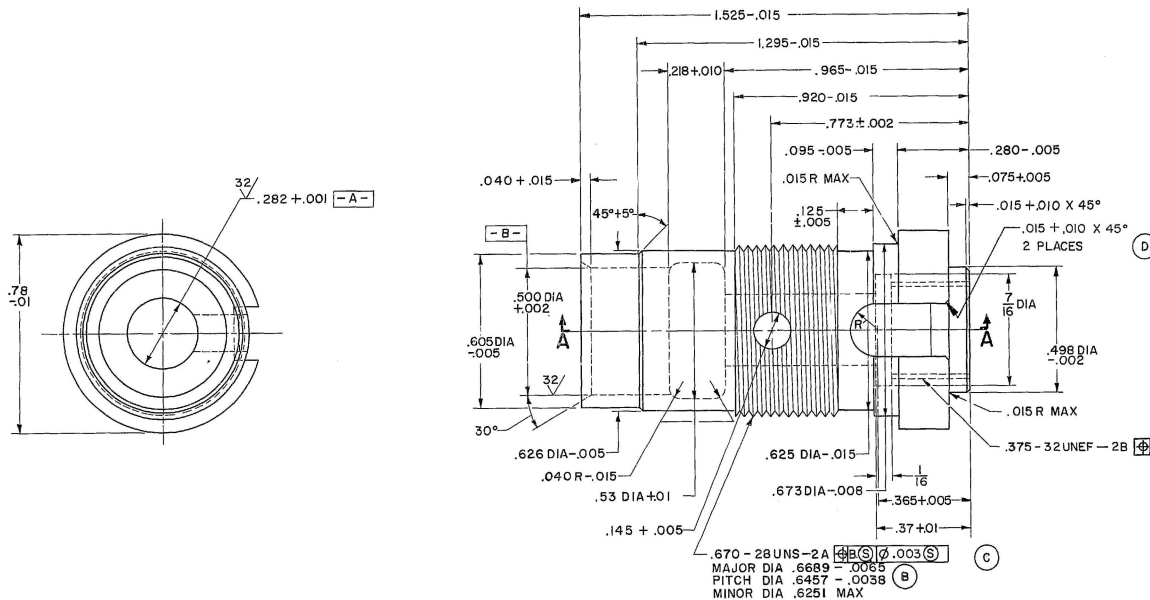
SYN	DESCRIPTION	DATE	APPROVAL
B*	SEE EO SA 25041	2 JUN 59	<i>R. H. H. H.</i>
A	REDRAWN AND REVISED	1 MAY 58	<i>R. H. H. H.</i>
9	WAS "B" SIZE	12 MAY 55	

PHYSICAL PROPERTIES	APPLICATION	FINAL PROTECTIVE FINISH	ORIGINAL DATE OF DRAWING	REVISIONS
C 7313114 30 BAR M1918 A2 SEE ENGINEERING RECORDS NEXT ASSY USED ON APPLICATION DO NOT APPLY PART NO. FILE HARD	30 BAR M1918 A2 SEE ENGINEERING RECORDS NEXT ASSY USED ON APPLICATION DO NOT APPLY PART NO. FILE HARD	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .01 ANGLES ± 1° MATERIAL STEEL, FED SPEC QQ-S-00640 FS 1020 HEAT TREATMENT SEE NOTE FINAL PROTECTIVE FINISH FINISH NO. 5.31 OR 5.33 OF MIL-STD-171	1 JUN 39 DRAFTSMAN C.H.C. CHECKER <i>R. H. H. H.</i> TRACER <i>R. H. H. H.</i> ENGINEER <i>R. H. H. H.</i> SUBMITTER <i>R. H. H. H.</i> APPROVED BY ORDER OF THE CHIEF OF BRANCH <i>R. H. H. H.</i> ORD CORPS	SPRINGFIELD ARMORY ORDNANCE CORPS DEPT OF THE ARMY SPRINGFIELD I, MASS DWG SIZE C 6147321 SHEET 1 OF 1

BODY, BUTT  
PLATE, OUTER

SCALE 1/1 UNIT WT. .20

CE 1



MIL-W-13655 APPLIES.

CORNERS AND EDGES SHALL BE .005 R ±.010 UNLESS OTHERWISE SPECIFIED.

125/ ALL OVER EXCEPT AS NOTED

HEAT TREATMENT: HEAT AT 1800°-1850°F. QUENCH IN OIL. TEMPER ONE HOUR AT MINIMUM OF 500°F TO R H SPECIFIED.

STEEL, CLASS 416, CONDITION A SPEC QQ-S-764.

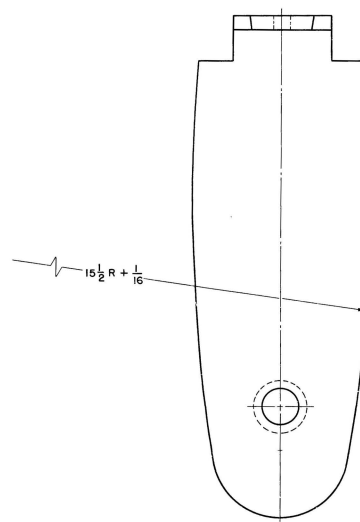
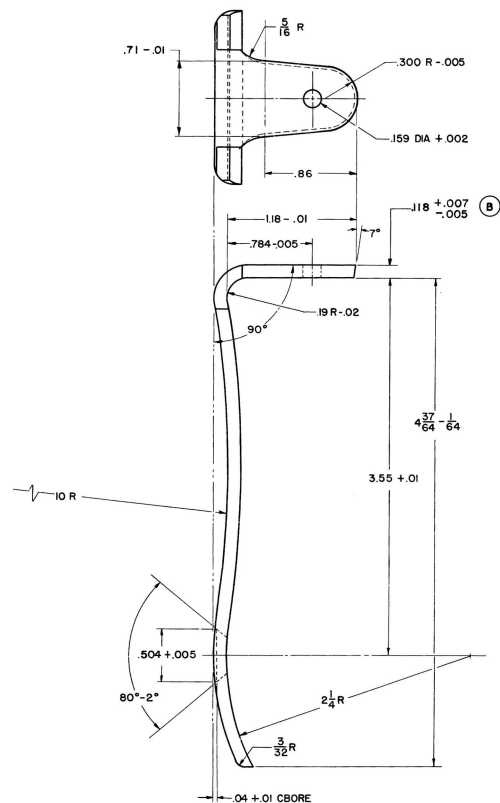
CODE IDENT NO. 19204  
PART NO. 7267818

PHYSICAL PROPERTIES		TOLERANCES ON DECIMALS ± .01		ORIGINAL DATE 27 MAY 1955	
SP		FRACTIONS 1/64		OF DRAWING	
TS		MATERIAL		CHECKER G-B-X	
EL	C7267819	30BARM1918A2		TRACER	
RA		SEE NOTE		ENGINEER	
BR		HEAT TREATMENT		SUBMITTED	
BR	C 35-42	SEE NOTE		APPROVED BY ORDER OF THE	
BR		FINISH NO. 3.3.3 OF MIL-STD-171		CHIEF OF ORDNANCE	

BODY, GAS CYLINDER		DEPT OF THE ARMY	
		ROCK ISLAND ARSENAL	
		ROCK ISLAND, ILL. 61201	
DWG NO. 7267818		D	
SCALE 4/1		UNIT WT .08	

D7267818

4. MIL-W-13855 APPLIES



D 5613687

CODE IDENT NO. 19204  
PART NO. 5613687

PHYSICAL PROPERTIES		RIFLE	WHEN OTHER SPECIFIC INSTRUCTIONS ARE ISSUED		ORIGINAL DATE	REVISONS	
C7313115		M1936(AZ)	TOLERANCES ON DECIMALS: .01		21 AUG 42	BODY, INNER BUTT	
TP			ANGLES: 1/16		BRITISH A.G. CHECKER	ROCK ISLAND, ARSENAL	
EL			MATERIAL		FRANCE	DEPT OF THE ARMY	
EL					ENGINEER & CHECKER	ROCK ISLAND, ILL. 61638	
BA			HEAT TREATMENT		SUBMITTER	ONE	
BA					DA Henderson	D 5613687	
BA					NO CORPS		
BA			APPLICATION		APPROVED BY	SCALE 2/1	
BA			F. IAL PROTECTIVE FINISH		1/16	LIMIT MAX 23	
BA			APPLY PART NO		1/16		
BA			-16-46976		1/16		

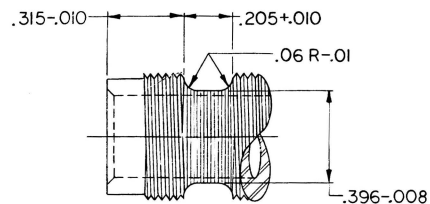
# NOTES:

1. STEEL, CMPSN 4140, ASTM A322 OR A331  
OR STEEL TUBING, SEAMLESS, CMPSN  
1035, ASTM A519.

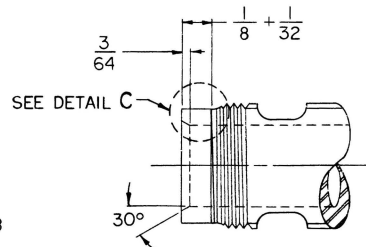
2. FINISH  $125\sqrt{\text{EXCEPT AS NOTED.}}$

3. MIL-W-13855 APPLIES.

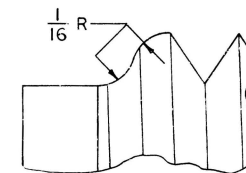
REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		B	REPLACES REV. A WITH CHANGE	21 SEP 75
			SEE NOR 75E0014-0002	



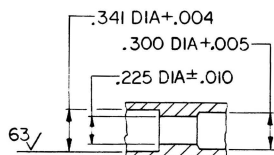
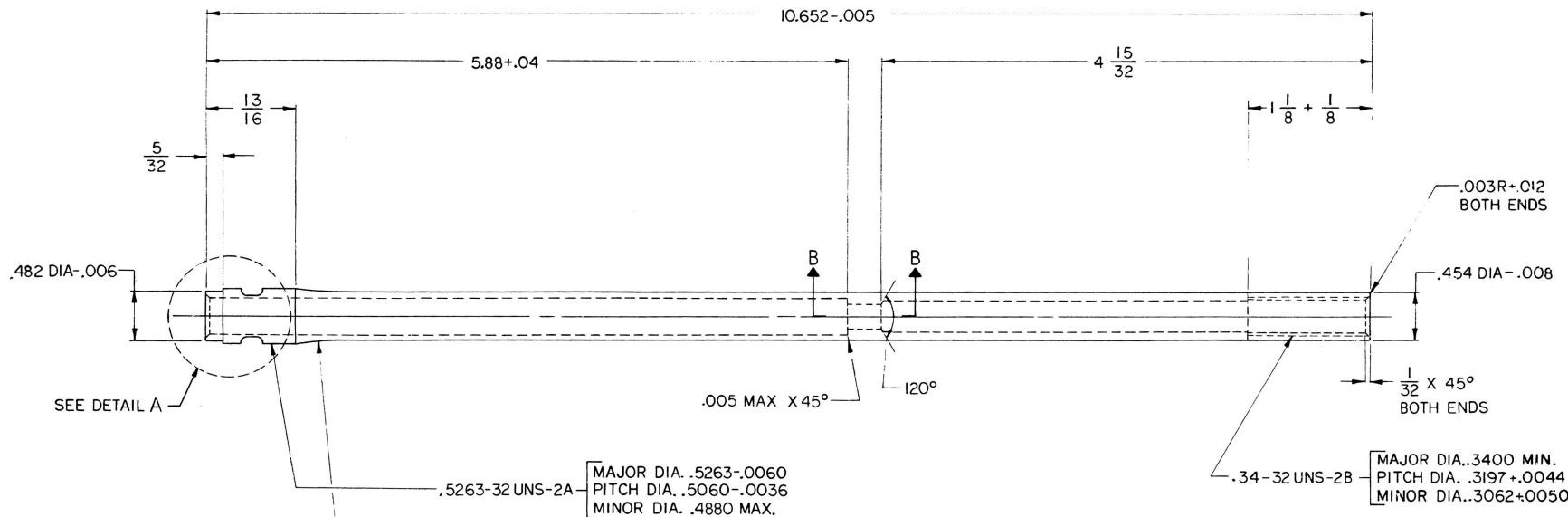
DETAIL A  
SCALE 4/1



ALTERNATIVE METHOD  
SCALE 4/1



DETAIL C  
SCALE 10/1



SECTION B-B

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 24 OCT 45		PART NO. 7313465	
YP		TOLERANCES ON DECIMALS FRACTIONS 1/64 ±.01		DESIGNED BY WE7/Manum		DEPT OF THE ARMY	
TS		ANGLES ± 2°		CHECKED BY [Signature]		ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
EL 2		MATERIAL		NOTED BY [Signature]		BODY, PISTON	
RA		SEE NOTE 1		ENGINEER [Signature]			
BH	D7313467	RIFLE, CAL. 30	HEAT TREATMENT	SUBMITTED BY [Signature]		DWG SIZE CODE IDENT NO D 19204 7313465	
RH		M1918A2 (BAR)	FINAL PROTECTIVE FINISH FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.	APPROVED BY [Signature]			
NEXT ASSY.		USED ON APPLICATION		SCALE 2/1		UNIT WT	

1. <sup>125</sup> ALL OVER EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .003±.012 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL:
  - A. FOR WROUGHT MATERIAL:  
STEEL, COMP 1020, SPEC. QQ-S-634.
  - B. FOR PRECISION CASTING:  
STEEL, COMP 108620, SPEC MIL-S-22141, EXCEPT CARBON .08-18 PERCENT. TENSILE TEST SHALL NOT APPLY.
4. HEAT TREATMENT:  
CARBURIZE AT 1600°±25°F TO CASE DEPTH .002 TO .005. TEMPER AT 350°F FOR 30 MINUTES. HEAT TREATMENT METHOD IS FOR GUIDANCE ONLY EXCEPT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. INSPECTION SHALL BE IN ACCORDANCE WITH CLASS IB, GRADE A, SPEC MIL-C-6021.
6. FILEHARD TEST IN ACCORDANCE WITH SA-STD-104.

Technical drawing of a mechanical part, likely a shaft or pin, showing dimensions and tolerances. The drawing includes a cross-section view on the right and a side view on the left. Key dimensions include: overall length  $.693 \pm .006$ , diameter  $.349 \pm .004$ , fillet radius  $.015 R$ , shoulder radius  $.500 R$ , and a  $30^\circ$  chamfer. The cross-section shows a diameter of  $.125$  and a fillet radius of  $.031 R$ . The part is labeled 'LY' on the left.

Technical drawing of a mechanical part with dimensions and tolerances:

- Overall width:  $.938$
- Top left corner:  $.18 - .01$
- Top center:  $.125$
- Top right corner:  $.031 + .015$
- Left side:  $.081 \text{ DIA} \pm .004$
- Bottom left corner:  $.127 \text{ DIA} - .002$
- Bottom center:  $.015 + .010 \times 45^\circ$
- Bottom right corner:  $.166 \text{ DIA} - .006$
- Internal angle:  $30^\circ$

Technical drawing of a shaft with a hole and a step. The hole is dimensioned as  $.125 \text{ DIA} + .002$ . The step is dimensioned as  $.127 - .004$ .

PIN

RIVET PIN SECURELY TO BODY

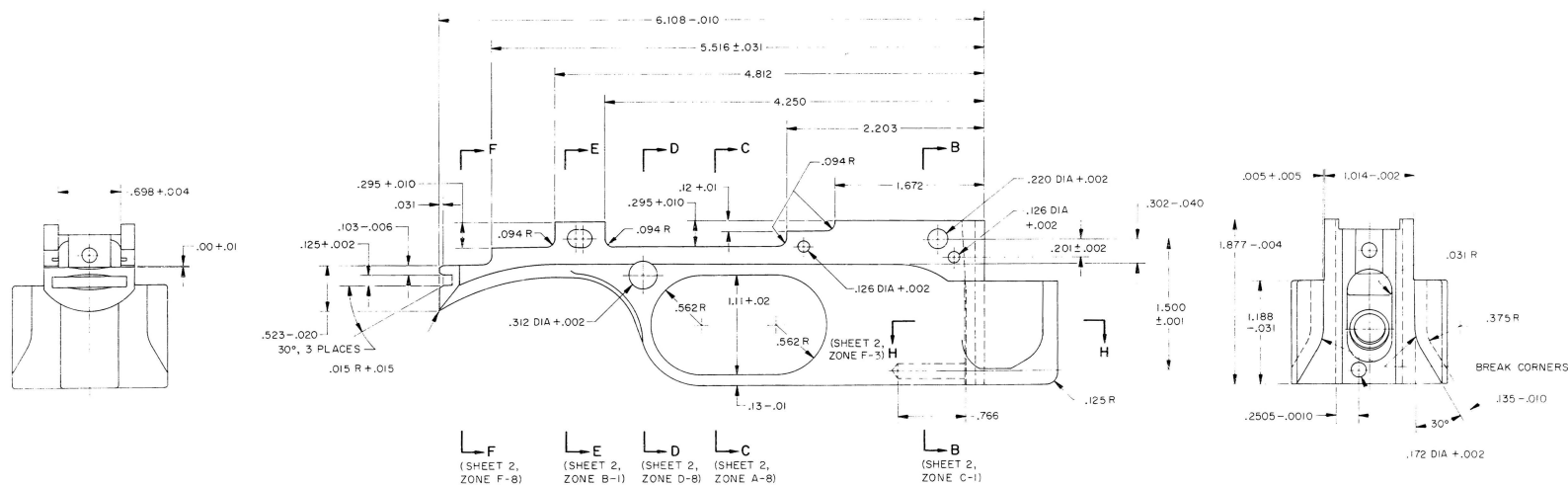
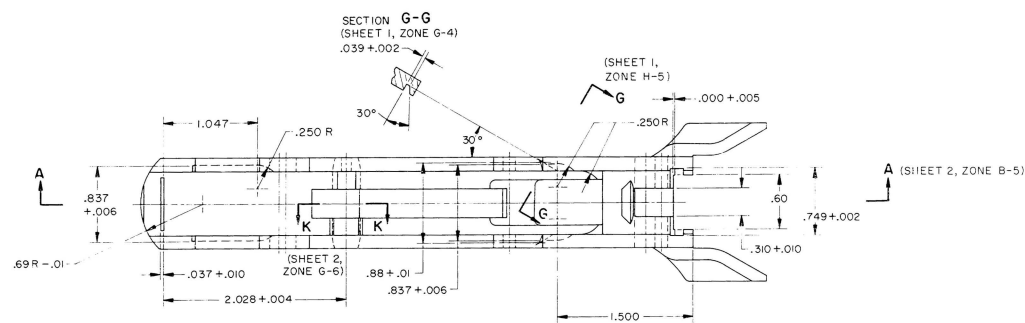
[illegible]

**REDUCED SIZE PRINT**





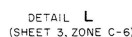
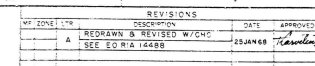
1. FINISH <sup>125</sup>/<sub>32</sub> AIL OVER. SEE NOTE 6, SHEET 3, FOR ALTERNATIVE DESIGN SURFACE FINISHES.
2. ALL GROOVES SHALL BE BROKEN .003 +.012 UNLESS OTHERWISE SPECIFIED.
3. 4. FOR WROUGHT MATERIAL:  
STEEL, COME 1035, SPEC. QU-S-634.
5. 6. FOR SELL MOLD PROCESS:  
IRON, MALLEABLE, PEARLITIC, CASTING, SPEC. MIL-I-11444, CLASS 6.
7. 4. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
8. 5. FOR ALTERNATIVE DESIGN SEE SHEETS 3 AND 4.



MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING		5 JUN 1940		DEPT OF THE ARMY	
		TOLERANCES: 1. $\frac{1}{16}$ 2. $\frac{1}{32}$ 3. $\frac{1}{64}$ 4. $\frac{1}{128}$		REVISED DATE		MEB		ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61210	
		PARTIAL		REVISION		EJA			
		SEE NOTE 3A		LSC		EJA			
F6535469 .30 BAR		HEAT TREATMENT		APPROVED		BODY, TRIGGER GUARD			
M1918A1		F		Philip H. Nelson		DRAWN DATE		1920A4	
NEXT ASS. USED IN APPLICATION		FINAL INSPECTOR		R. P. Henry		DATE		JUN 24 1940	
		SEE NOTE 4						6535470	

REDUCED SIZE PRINT

6.  $\frac{250}{\sqrt{}}$  ALL OVER EXCEPT SURFACE MARKED  
 $\sqrt{}$  SHALL BE  $\frac{125}{\sqrt{}}$ .



MECHANICAL TOLERANCES		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE IN INCHES		ORIGINAL DATE OF DRAWING		PART NO. 6535470	
		TOLERANCES ON: .0005		30 MAR 1953		DEPT OF THE ARMY	
FRACTIONS .0005		ANGLES 1" .0005		J.P. D.H.		ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
TITLES		SEE NOTE 39, SHEET 1		J.P. D.H.		BODY, TRIGGER GUARD (ALTERNATIVE DESIGN)	
EL. 3.2		TREAT TREATMENT		R.S.H. L.J.L.			
3.2		F6535469 .30 BAR		SIGNED: <i>C. H. Hank</i>			
3.2		M1916A2		APPROVED: <i>R. S. Hines</i>		DWG. SIZE (CODE IDENT. NO.)	
3.2		NEXT ASSY. USED ON		FINAL PROTECTIVE FINISH		F 19204 6535470	
3.2		APPLICATION		SEE NOTE 40, SHEET 1		SCALE 2" = 1" UNIT WEIGHT 3.2 SHEET 3 OF 4	

SCALE 2/1 UNIT WT. 5

**REDUCED SIZE PRINT**

Technical drawing of a mechanical part showing dimensions: .312, .250 R, and .04.

SCALE 2/1 UNIT WT SHEET  
**REDUCED SIZE PRINT**

8

7

6

5

4

3

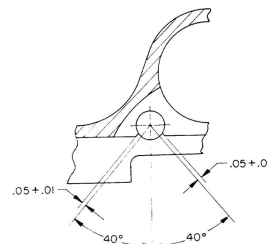
2

1

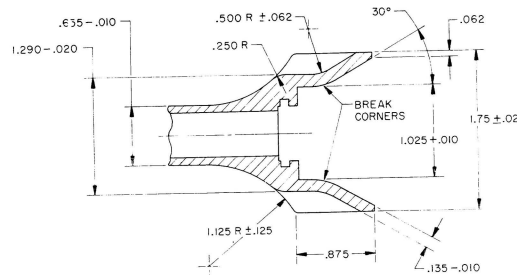
REVISIONS			
NO.	DATE	DESCRIPTION	BY
1	15 JUN 48	REBORN & REVISED W7C-0 SEE EO 14-1A488	Handwritten



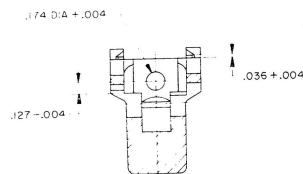
SECTION F-F  
(SHEET 1, ZONE C-6)



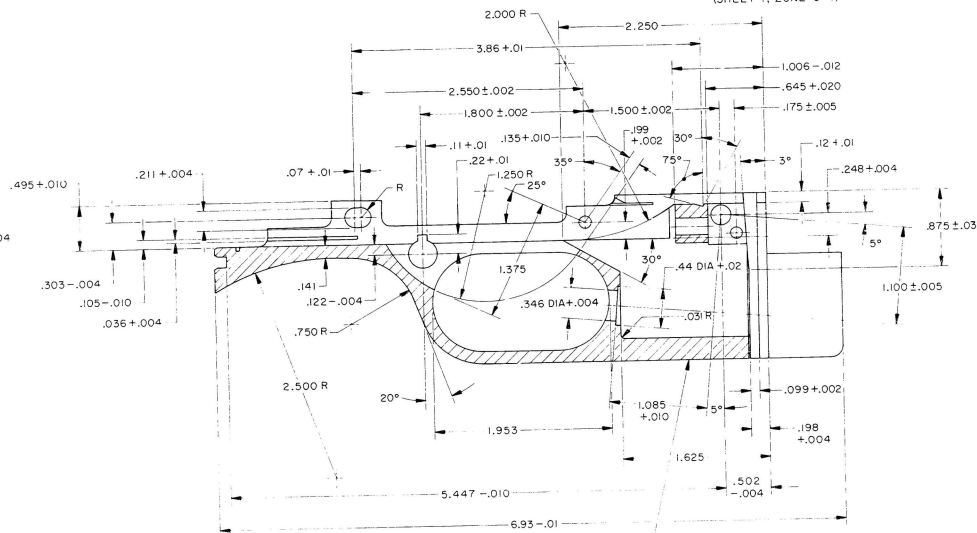
SECTION K-K  
(SHEET 1, ZONE F-5)



SECTION H-H  
(SHEET 1, ZONE C-4)

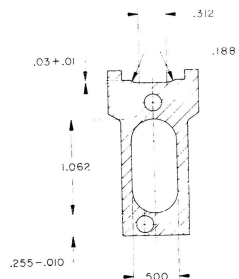


SECTION D-D  
(SHEET 1, ZONE C-5)

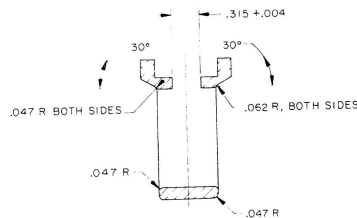


SECTION A-A  
(SHEET 1, ZONE G-3)

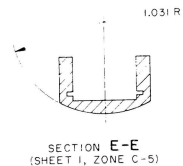
INSCRIBE PART NO. 6535470,  
.062 HIGH PER MIL-STD-130.



SECTION B-B  
(SHEET 1, ZONE C-4)



SECTION C-C  
(SHEET 1, ZONE C-4)



SECTION E-E  
(SHEET 1, ZONE C-5)

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS & DECIMALS SEE NOTE 3A, SHEET 1		ORIGINAL DATE OF DRAWING 5 JUN 1940	DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 61201
NO.	F6535469	30 BAR, M181A2	HEAT TREATMENT TEMP ON	APPROVED Handwritten	DATE 19204
HEAT TREATMENT	TEMP ON	APPROVED	DATE	19204	6535470
APPROVED	DATE	19204	6535470	SHEET 2 OF 4	

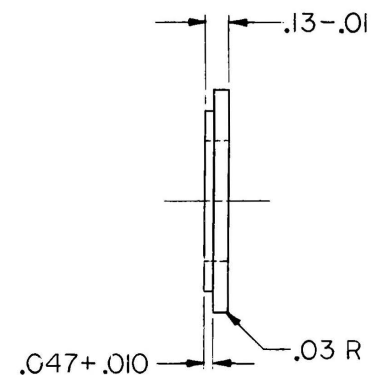
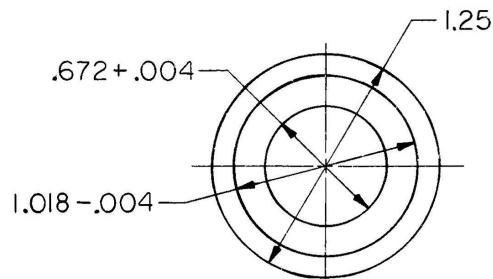
REDUCED SIZE PRINT

NOTES:

1. STEEL, CMPSN 1018 THRU 1040,  
SPEC QQ-S-631 OR ASTM A108.

2. FINISH  $125/\sqrt{\text{ALL OVER.}}$

3. MIL-W-13855 APPLIES.



REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	REPLACES REV 7 W/CHANGE SEE ERR HQR 50626	18 MAR 75

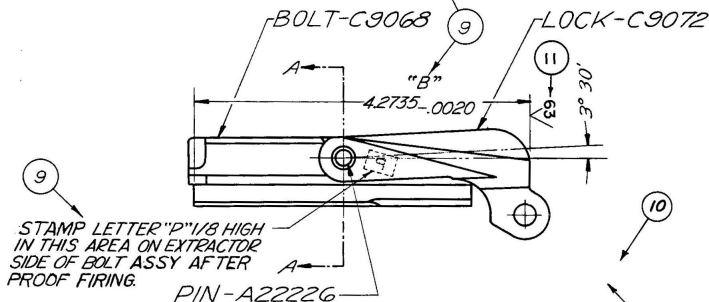
PART NO. 5152770

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING		DEPT OF THE ARMY	
YS MIN		TOLERANCES ON DECIMALS .XX ± .01		JUN 39		ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YS MAX		ANGLES ± XXX ±		DRAFTSMAN G. Conway		BODY, WASHER	
EL 2		MATERIAL		TRACER			
RA		SEE NOTE 1		ENGINEER G. Winter			
BH		HEAT TREATMENT		SUBMITTED		DWG SIZE	
RH		FINAL PROTECTIVE FINISH		APPROVED		CODE IDENT NO.	
APPLICATION				D. A. Cole		B 19204	
NEXT ASSY.		USED ON				5152770	
						SCALE 2/1 UNIT WT SHEET 1 OF 1	

NOTICE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED IN WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

# HEAT TREATMENT & FINAL FINISH

NOTE: DIMENSION "B" TO GAGE 4.2735-.0025 AFTER PROOF FIRING.



DO NOT INSCRIBE PART NO.

PHYSICAL PROPERTIES

MAY 1, 1929

REVISIONS	
Y.P.	2 6-1-36
T.S.	3 4-15-38
EL-2	4 6-1-39
RED	5 4-10-41
HT.T.	6 1-2-42
BR.	7 4-15-44
	85 CONVERSION 1-28-49
SCL.	92 4-8-52
C.C.	10 2-4-53
	11 12 MAY 54
	12 9 JUNE 55
	13 19 AUG 55

DRG. PERTAINS TO

513 30 BAR M19  
FT265701 30 BAR M191A2

SYMBOL

RXB 3

DFTSMAN	TRACER	LDC DFTSMAN
E.L.J.	100	100
CHECKER	100	100
L.A.G.	100	100

SUBMITTED  
CAPT. ORD. DEPT. U.S.A.

APPROVED BY ORDER OF THE  
CHIEF OF ORDNANCE  
LT. COL. ORD. DEPT. U.S.A.

ORDNANCE DEPT. U.S.A.

SUPERSEDES B19695

## LIST OF COMPONENTS

1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NUMBER REQUIRED
1	B19695	BOLT, ASSEMBLY	(1)
2		COMPOSED OF:	
3	C9068	1-BOLT	*
4	C9072	1-LOCK, BOLT	
5	A22226	1-PIN, BOLT LOCK	

BOLT, ASSEMBLY B19695-5

THE REAR SURFACE OF THE LOCK SHALL BE GROUND TO DIMENSION "B". THIS DIMENSION SHALL NOT VARY MORE THAN .001 ACROSS THE ENTIRE WIDTH OF THE LOCK WHEN THE RADIAL CAMMING SURFACES OF THE LOCK ARE PRESSED FIRMLY AGAINST THE MATING SURFACES OF THE BOLT.

BLEND RADII TO LOCKING SURFACE AFTER GRINDING.

DWG B7266102 APPLIES

\*WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.  
SUPERSEDES OLD TRACING B19695 UNDER REVISION DATE OF JUNE 1, 1936

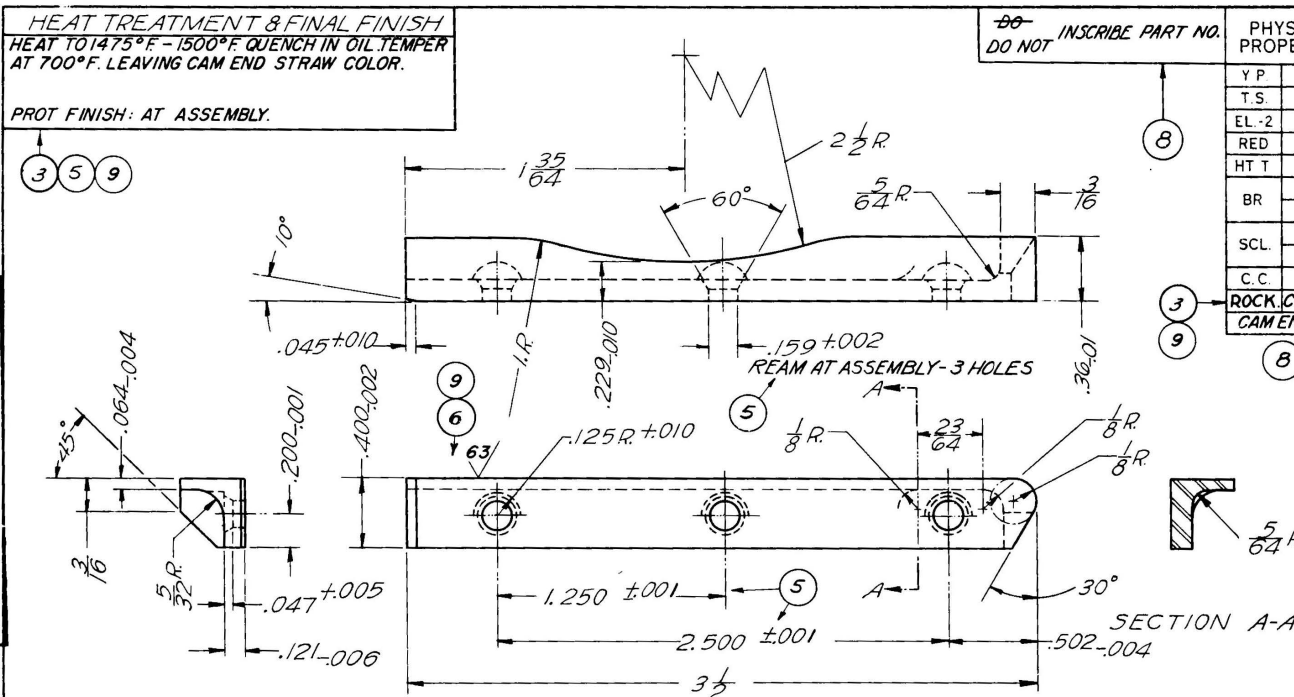
B6019695

B19695

B6019695

NOTICE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH THE UNITED STATES GOVERNMENT PROCUREMENT.

HEAT TREATMENT & FINAL FINISH  
HEAT TO 1475°F - 1500°F. QUENCH IN OIL. TEMPER  
AT 700°F. LEAVING CAM END STRAW COLOR.  
PROT FINISH: AT ASSEMBLY.



6019663  
SUPPORT BOLT, LEFT  
STEEL, SPEC MIL - S - 13502: ORD 1050 MODIFIED  
125/ ALL OVER EXCEPT AS NOTED  
6019663 6  
B19663 6  
6  
8  
3 5  
7

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.  
SUPERSEDES OLD TRACING B19663 UNDER REVISION DATE OF JUNE 1, 1936.  
DWG B7266102 APPLIES

DO NOT INSCRIBE PART NO.

PHYSICAL PROPERTIES		MAY 1, 1929	
		REVISIONS	
Y P		1	6-1336
T.S.		2	4-15-38
EL-2		3	6-1-39
RED		4	6-25-40
HT T		5	12-15-42
BR		6	4-17-44
		7	1-21-49
SCL		8	1-20-49
		9	19 AUG 55
C.C.			
ROCK C40-45			
CAM END C45-50			

DRG PERTAINS TO  
B8770 RECEIVER, ASSEMBLY  
51-19-30 B.A.R. M-18  
51-19-30 B.A.R. M-19/1842  
B35472 RECEIVER, ASM  
D6535472

SYMBOL

JDS 670

DFTSMAN	TRACER	L.D.G. DFTSMAN
ELJ	ELJ	ELJ
CHECKER	CHECKER	CHIEF DFTSMAN
2.2.6	2.2.6	2.2.6
SUBMITTED		
CAPT. ORD DEPT U.S.A.		
APPROVED BY ORDER OF THE CHIEF OF BUREAU		
S. I. [Signature]		
LT COL. ORD DEPT U.S.A.		
ORDNANCE DEPT U.S.A.		

NOTICE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

SCALE 2  
B6019663  
B19663

SUPERSEDES B19663

B6019663



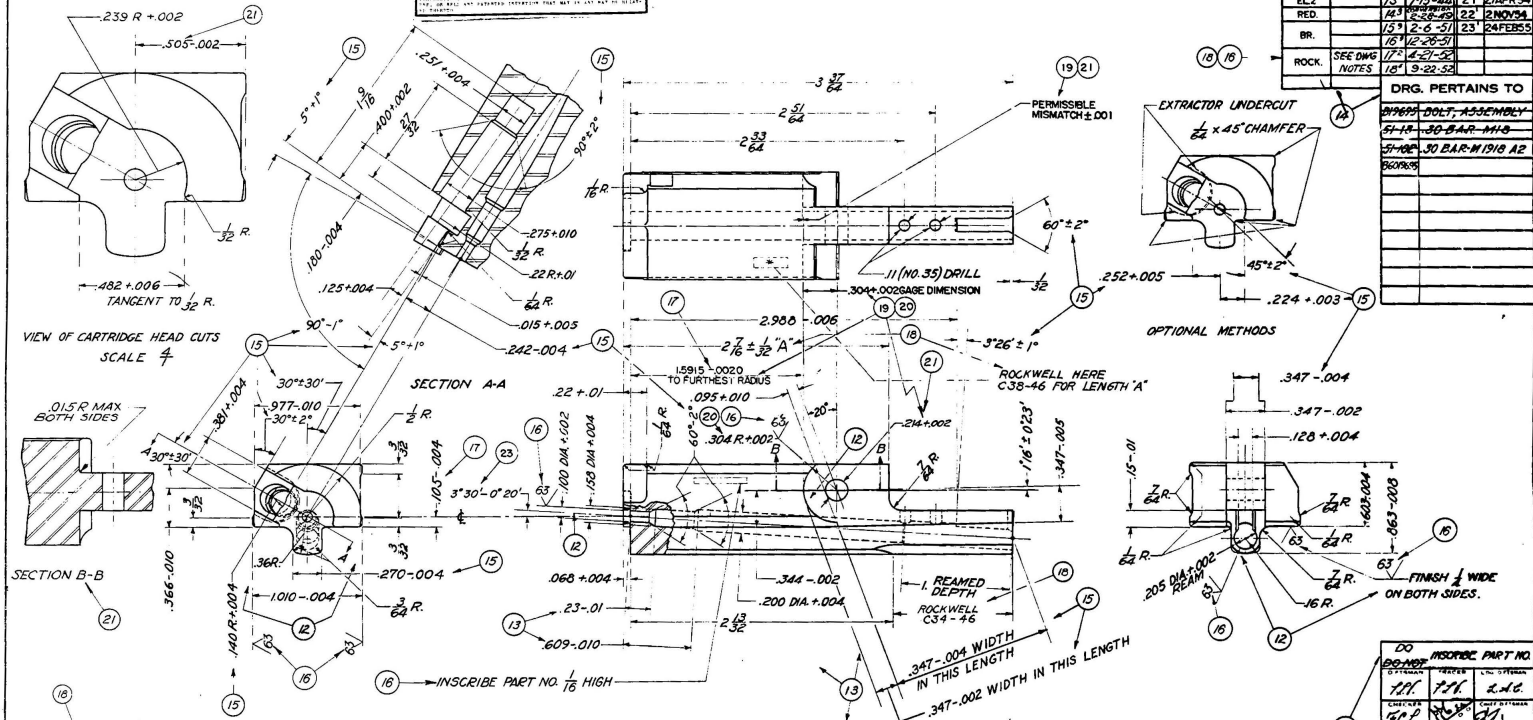
# 23046

HEAT TREATMENT & FINAL FINISH  
HEAT TO 1475°F - 1500°F. QUENCH IN OIL. TEMPER  
TO ROCKWELL'S SPECIFIED.  
PROT. FIN. TYPE II CLASS A USA 57-0-2

NOTES: 1. THIS DRAWING IS A TECHNICAL SPECIFICATION FOR THE  
MANUFACTURE OF A CARTRIDGE HEAD. THE DRAWING IS TO BE  
CONSIDERED AS A PART OF THE CONTRACT. THE CONTRACTOR  
IS RESPONSIBLE FOR THE INTERPRETATION OF THE DRAWING  
AND FOR THE MANUFACTURE OF THE CARTRIDGE HEAD.  
THE CONTRACTOR IS RESPONSIBLE FOR THE INTERPRETATION  
OF THE DRAWING AND FOR THE MANUFACTURE OF THE  
CARTRIDGE HEAD. THE CONTRACTOR IS RESPONSIBLE  
FOR THE INTERPRETATION OF THE DRAWING AND FOR  
THE MANUFACTURE OF THE CARTRIDGE HEAD.

PHYSICAL PROPERTIES		MAY 1, 1929			
		REVISIONS			
Y.P.		11	3-16-44	19	12-9-52
T.S.		12	4-17-44	20	2-4-53
EL.		13	7-15-44	21	27APR54
RED.		14	8-2-44	22	2NOV54
BR.		15	2-6-51	23	24FEB53
		16	12-26-51		
ROCK.	SEE DWG	17	4-27-52		
	NOTES	18	9-22-52		

DRG. PERTAINS TO	
HYPERA BOLT ASSEMBLY	
51-18 30 BAR MHS	
51-100 30 BAR MHS AB	
560885	



RETEMPERING OF SMALL END, IF NECESSARY, SHOULD  
BE CONTROLLED IN SUCH A MANNER AS TO RETAIN  
SPECIFIED HARDNESS FOR LENGTH 'A'

TOLERANCE  $\pm .01$  ALLOWED ON ALL DIMEN-  
SIONS UNLESS OTHERWISE SPECIFIED.  
SUPERSEDES OLD TRACING C9068 UNDER REVISION DATE OF MARCH 16, 1944

16 STEEL SPEC ML-S-13502; ORD 1050  
MODIFIED, GUN QUALITY  
FINISH 125 EXCEPT AS NOTED

NOTES: THIS DRAWING SHALL NOT BE USED OR  
REPRODUCED EITHER WHOLLY OR IN PART EXCEPT  
WHEN AUTHORIZED IN CONNECTION WITH  
UNITED STATES GOVERNMENT PROCUREMENT.

DO NOT REPRODUCE PART NO.  
51-18 30 BAR MHS  
51-100 30 BAR MHS AB  
560885  
SUBMITTED  
APPROVED BY ORDER OF THE  
CHIEF OF ORDNANCE  
ORDNANCE DEPT. U. S. A.

DWG. BT268102 APPLIES

SCALE 7

C5509068  
C9068

SUPERSEDES C9068

4

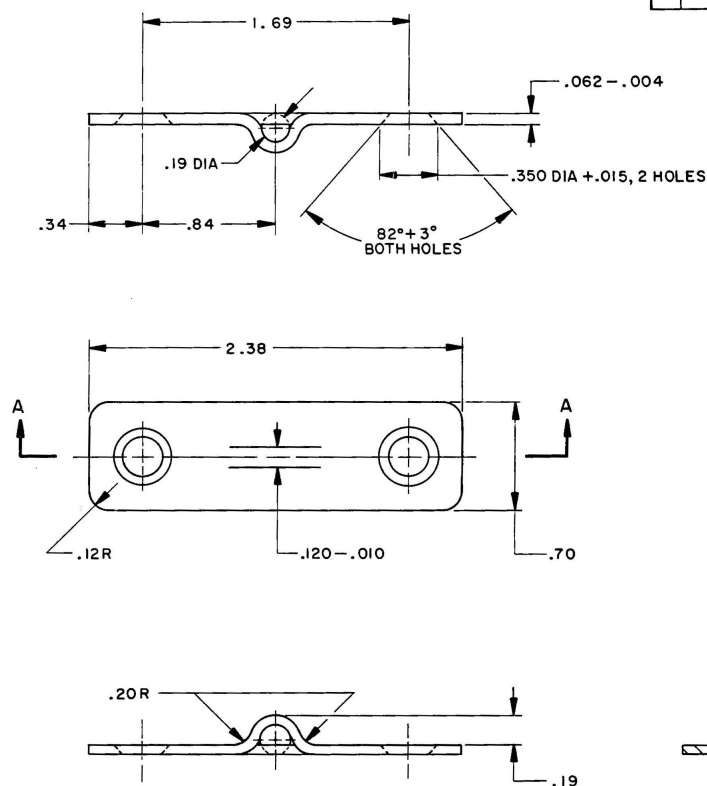
3

2

1

- NOTES: 1. FINISH  $\sqrt{25}$  ALL OVER.  
 2. BREAK ALL EXTERIOR EDGES .015R.  
 3. MATERIAL:  
 STEEL, COND CR, COMP 1009,  
 SPEC QQ-S-698.

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	REDRAWN & REVISED W/CHANGE SEE EO RIA-14533	10 DEC 1967



PART NO. 7266114

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 15, OCT 1951		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL 61201	
YP		TOLERANCES ON DECIMALS .XX ± .01		DRAFTSMAN D.H.	CHECKER R.M.P	BRACKET, BUTT SWIVEL	
TS		ANGLES ± 1° .XXX ±		TRACER J. P. Duggan	CHECKER R.W.M		
EL 2		MATERIAL SEE NOTE 3		ENGINEER R.W.M			
RA		HEAT TREATMENT		SUBMITTED Philip E. Hebert			
BH	C7266132	.30 BAR M18A2		APPROVED R. S. Henry		DWG SIZE C	CODE IDENT NO 19204
RH		NEXT ASSY.	USED ON	FINAL PROTECTIVE FINISH		SCALE 2/1	UNIT WT
		APPLICATION				SHEET	

NOTICE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

HEAT TREATMENT & PROT. FINISH

PROT. FIN. TYPE II CLASS A OR B USA 57-0-2

~~DO~~ INSCRIBE PART NO.

PHYSICAL PROPERTIES

~~A22213~~  
MAY 1, 1929

REVISIONS

Y. P.	2	6-1-36	7	1-21-49
T. S.	3	4-15-38	8	CONVERSION 1-28-49
EL-2	4	6-1-39	9	4-25-52
RED.	5	10-12-43	10	12 MAY 55
HT. T.	6	4-15-44		

DRG. PERTAINS TO

BR.	C 64073	SWIVEL, FRONT, ASM.
SCL.	51-13	30 B.A.R. M-13
C. C.	C5564073	
	51-102	30 BAR-M18 A2

SYMBOL

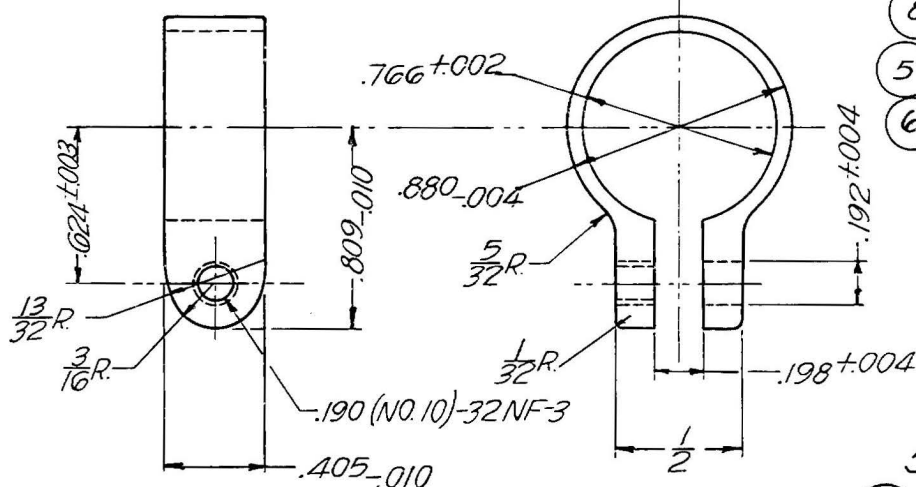
PIB 1528

D'FTSMAN	TRACER	L'D'G. D'FTSMAN
E. L. J.	J. J. V.	O. J. C.
CHECKER	CHIEF D'FTSMAN	
L. S. C.	SA	SA

SUBMITTED  
J. J. V.  
CAPT, ORD. DEPT. U.S.A.

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:  
S. J. S.  
LT. COL, ORD. DEPT. U.S.A.

ORDNANCE DEPT. U.S.A.



BRACKET, FRONT SWIVEL

STEEL, FED SPEC QQ-S-00640: FS 1020 OR  
STEEL (BAR) FED SPEC QQ-S-633: FS 1020

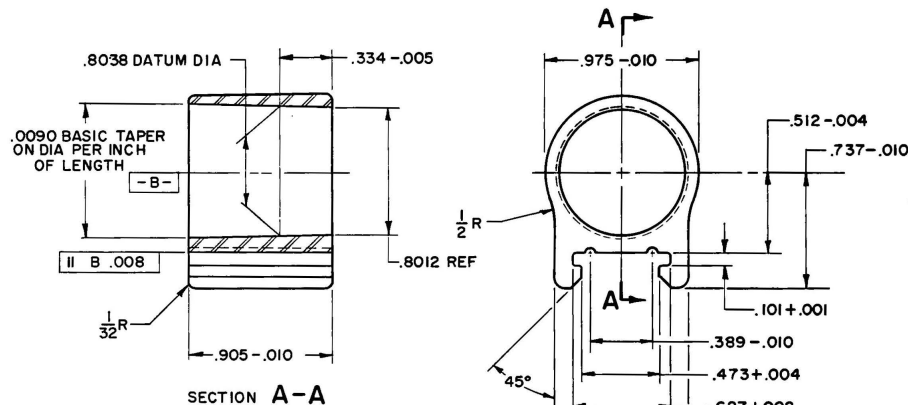
TOLERANCE ± .01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.  
SUPERSEDES OLD TRACING A22213  
UNDER REVISION DATE OF JUNE 1, 1936

SCALE 2  
DWG B7266102 APPLIES

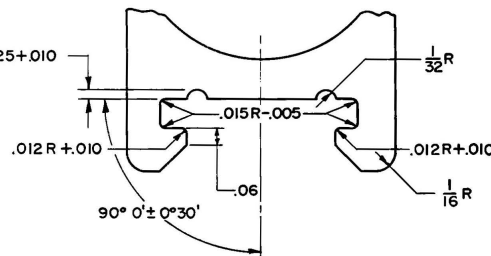
5022213  
~~A22213 2~~  
A5022213  
~~A22213~~

SUPERSEDES A22213

NOTICE: WHEN GOVERNMENT DRAWINGS SPECIFICATIONS OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY APPOINTED GOVERNMENT PROCUREMENT OPERATION THE UNITED STATES GOVERNMENT TAKES NO RESPONSIBILITY FOR ANY CONSEQUENCES WHATSOEVER AND THE FACT THAT THE GOVERNMENT HAS MADE AVAILABLE FOR PUBLIC USE IN ANY MANNER DOES NOT CONSTITUTE AN ENDORSEMENT OR A GUARANTEE OF THE ACCURACY OF THE DATA OR THE RESULTS THEREOF. THE USER OF THIS DATA SHALL BE RESPONSIBLE FOR THE RESULTS OF ANY USE THEREOF. THE USER OF THIS DATA SHALL BE RESPONSIBLE FOR THE RESULTS OF ANY USE THEREOF. THE USER OF THIS DATA SHALL BE RESPONSIBLE FOR THE RESULTS OF ANY USE THEREOF.



SECTION A-A



ENLARGED VIEW

SCALE 4/1

C 6019634

- ⊕ FOR PRECISION CASTING:
- MATERIAL: NOMINALLY FS 1050
  - \* CARBON 0.45 - 0.55 PER CENT
  - \* MANGANESE 0.60 - 0.90 " "
  - \* SILICON 0.23 - 0.72 " "
  - \* SULPHUR 0.050 MAX " "
  - \* PHOSPHORUS 0.040 MAX " "

\* PERTAINS TO SCHEDULES ON DWG D7267837 FOR PRECISION CASTINGS.

SPEC MIL-C-10005 (ORD) AND DWG D7267837, GENERAL REQUIREMENTS FOR PRECISION CASTINGS, SHALL APPLY.

CHEMICAL ANALYSIS SHALL BE IN ACCORDANCE WITH SCHEDULES A, B, AND C DWG D7267837.

MECHANICAL TEST AND INSPECTION SHALL BE IN ACCORDANCE WITH APPLICABLE SPECIFICATIONS AND DRAWINGS.

THE ACCEPTABLE QUALITY LEVEL FOR RADIOGRAPHIC INSPECTION SHALL BE Q.65 ON A LOT SIZE AS DEFINED ON DWG D 7267837 USING LEVEL II OF MIL-STD-105, SINGLE SAMPLING PLAN.

DWG D7267837 APPLIES  
DWG B7266102 APPLIES

ORD PART NO. 6019634

REV	DESCRIPTION	DATE	APPROVAL
A	REDRAWN AND REVISED	11 JAN 57	[Signature]
9	WAS "B" SIZE, E.O. SA 24203	18 MAR 53	

FINISH ALL OVER 125

HEAT TREATMENT: HEAT TO 1475°F TO 1525°F. OIL QUENCH. TEMPER FOR 30 MINUTES TO RH SPECIFIED.

PHYSICAL PROPERTIES	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE OF DRAWING
ITEM	D6508769 30 BAR M1918	1 MAY 29
TS	A2	DRAWN BY E. J.
EL2	SEE ENGINEERING RECORDS	CHECKER C.S.S.
RA		TRACER [Signature]
BN	NEXT ASSY USED ON	ENGINEER [Signature]
RK	APPLICATION	SUBMITTED
	DO NOT APPLY PART NO.	APPROVED BY ORDER OF THE CHIEF OF ORDNANCE
	AS SPECIFIED	[Signature]
	FINAL PROTECTIVE FINISH TYPE I OR II SPEC MIL-C-16232	

BRACKET,  
GAS CYLINDER  
TUBE

SPRINGFIELD ARMORY  
ORDNANCE CORPS  
DEPT OF THE ARMY  
SPRINGFIELD 1, MASS.

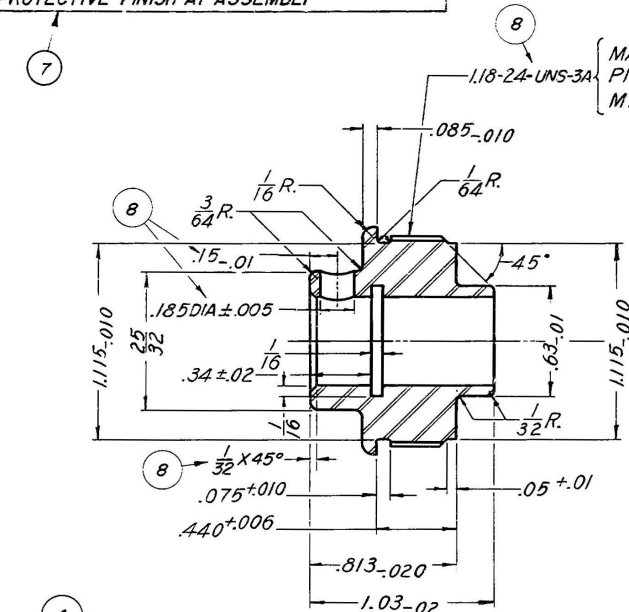
DWG NO. 6019634

C SHEET 1 OF 1

SCALE 2/1 UNIT WT .09

HEAT TREATMENT & PROT FINISH

PROTECTIVE FINISH AT ASSEMBLY



ALTERNATIVE METHOD: ELIMINATE 1/16 WIDE BRAZING WIRE GROOVE AND USE 1/32 X 45° CHAMFER FOR BRAZING MATERIAL.

CAP. BUFFER TUBE (B147485-2) 6147485

STEEL FS B1112 FED SPEC QQ-S-633

FINISH 125/

MANUFACTURING COMPONENT

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

DWG B7266102 APPLIES

SCALE 2/1

PHYSICAL PROPERTIES

Y.P.  
T.S.  
EL. 2  
RED.  
BR.  
ROCK.  
SCL.

JUNE 5, 1940

REVISIONS

1	12-26-40	7	7-25-52
2	10-6-41	8	10 APR 56
3	4-25-42		
4	12-8-42		
5	3-1-43		
6	1-28-43		

D'R.G. PERTAINS TO

51-102-308A.R.M1918-A2

B147495 TUBE WITH CAP, ASM.

B6147485

SYMBOL

DO INSCRIBE PART NO.

DO NOT

OFFICER TRACER LOG OFFICER

CHECKER

SUBMITTED

MAJORS DEPT. U.S.A.

APPROVED BY ORDER OF THE

CHIEF OF ORDNANCE

ORDNANCE DEPT. U.S.A.

SUPERSEDES B147485

B6147485

4

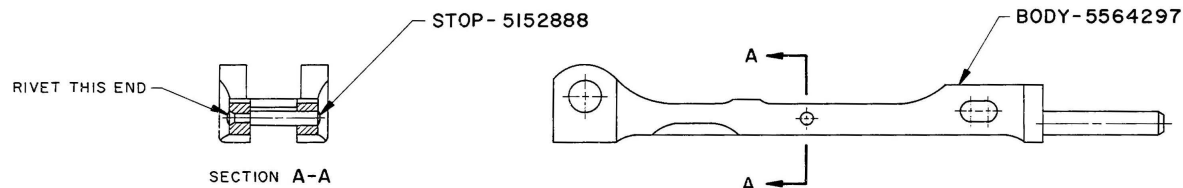
3

2

## NOTES:

I. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	REDRAWN & REVISED W/CHG SEE EO RIA-14488	25 JAN 68



## LIST OF PARTS, SEE ENGINEERING PARTS LIST- 6147499

PART NO. 6147499

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 5 JUN 1940		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON	DECIMALS .XX ±	DRAFTSMAN HJO	CHECKER CHC	CARRIER, SEAR, ASSEMBLY	
TS		ANGLES ±	.XXX ±	TRACER J. Van Lierberghe	CHECKER EJA		
EL 2		MATERIAL		ENGINEER CJT	ENGINEER EJA		
RA		HEAT TREATMENT		SUBMITTED Philip E. Hebert			
BH		F6535469	.30 BAR.	APPROVED R. L. Henry		DWG SIZE C	CODE IDENT NO. 19204
RH		NEXT ASSY.	USED ON	FINAL PROTECTIVE FINISH SEE NOTE I		SCALE 2/1	UNIT WT
		APPLICATION				SHEET 1	OF 1

4

3

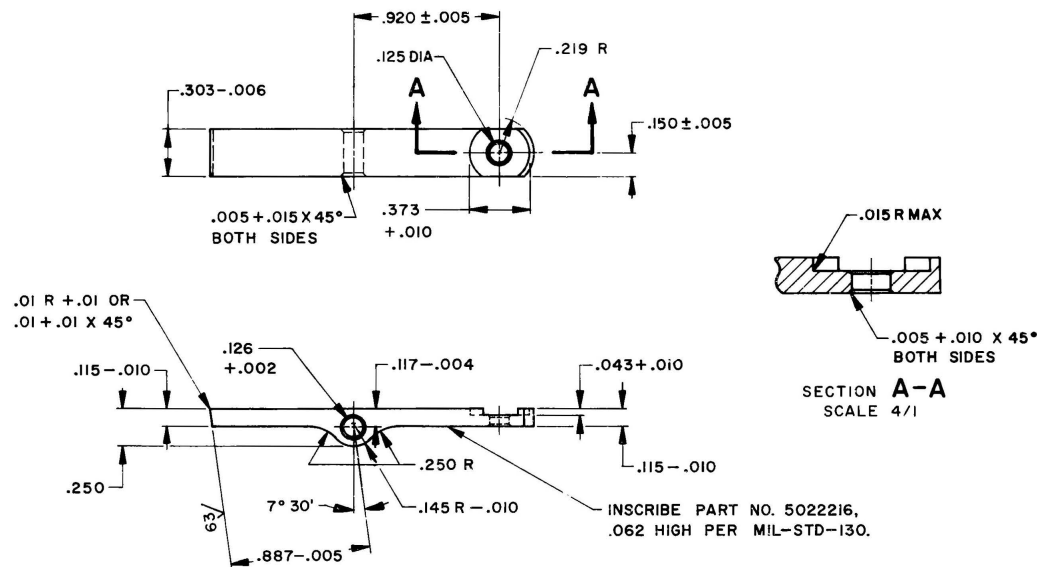
2

1

## NOTES:

1. FINISH  $125\sqrt{\text{ }}$  EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN  $.003 + .012$  UNLESS OTHERWISE SPECIFIED.
3. MATERIAL:  
STEEL, COMP 1080 OR 1095,  
SPEC QQ-S-631 OR QQ-S-634.
4. HEAT TREATMENT:  
HEAT AT 1475° TO 1500° F. OIL QUENCH.  
TEMPER 1 HOUR TO HARDNESS SPECIFIED.  
HEAT TREATMENT METHOD IS FOR  
GUIDANCE ONLY EXCEPT TEMPERING  
TIME SHALL NOT BE REDUCED BELOW  
THAT SPECIFIED.
5. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OF MIL-STD-171.

REVISIONS			
LTZ	DESCRIPTION	DATE	APPROVED
A	REDRAWN & REVISED W/CHANGE SEE EC RIA-14488	25 JAN 68	<i>Karvelm</i>



PART NO. 5022216

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 MAY 1929		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON DECIMALS $\pm .015$		DRAFTSMAN	D.E.P.	CHECKER	L.S.C.
TS		FRACTIONS ANGLES $\pm 1^\circ$		TRACER	<i>T. King</i>	CHECKER	<i>W.H.</i>
EL 2		MATERIAL		ENGINEER	L.S.C.	ENGINEER	E.J.A.
RA		SEE NOTE 3		SUBMITTED			
BH		HEAT TREATMENT		APPROVED <i>Philip E. Hebert</i>			
RH	C 42-47	SEE NOTE 4		APPROVED <i>E. S. Henry</i>			
APPLICATION		FINAL PROTECTIVE FINISH		DWG SIZE C CODE IDENT NO. 19204			
NEXT ASSY USED ON		SEE NOTE 5		SCALE 2/1 UNIT WT SHEET 1 OF 1			
APPLY PART NO.				5022216			

CATCH, MAGAZINE

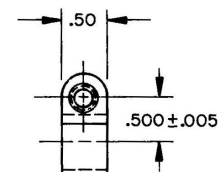
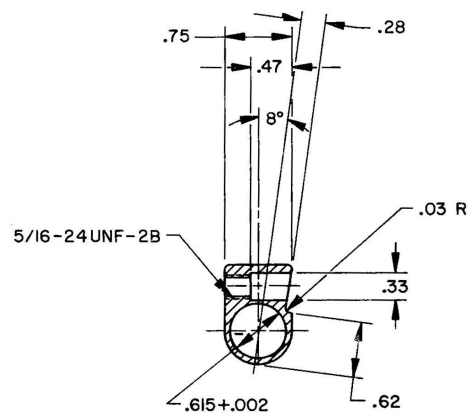


NOTES:

1. FINISH ALL OVER  $\sqrt{125}$ .

2. MATERIAL:

STEEL, COMP 1020, SPEC QQ-S-631  
OR SPEC QQ-S-634.



REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	REDRAWN & REVISED W/CHG SEE EO 82075	8 APR 68	P. Heberle

PART NO. 5152777

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 JUNE 1939		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON DECIMALS .XX ± .01		DRAFTSMAN DEP	CHECKER FLV	CLAMP, LEG	
TS		ANGLES ± XXX ±		TRACER A. A. G. Smith	CHECKER P. Heberle		
EL 2		MATERIAL SEE NOTE 2		ENGINEER W. R. Ash	ENGINEER P. Heberle		
RA	C 7312236	.30BAR-M18A2	HEAT TREATMENT	SUBMITTED Philip E. Heberle		DWG SIZE B	CODE IDENT NO. 19204
BH	B 7312237	.30BMG-M19A6	FINAL PROTECTIVE FINISH	APPROVED K. J. Henry		5152777	
RH	APPLICATION		SCALE 1/1 UNIT WT SHEET 1 OF 1				

SWER1 FORM 40B. 1 MAR 67

HEAT TREATMENT & PROT. FINISH		PHYSICAL PROPERTIES				A-152882 JUNE 5, 1940	
Y.P.		RED.		SCL.	REVISIONS		
T.S.		BR.			1	11-22-40	5' 3-1-43
EL. 2		ROCK.			2	4-28-41	6' 3-1-43
					3	4-25-42	7' 3-25-52
					4	12-14-42	

PROT. FIN. AT ASSEMBLY

FINISHED LENGTH AFTER ASSEMBLY

80-01

624+002

041+005

041+005

COLLAR, SLEEVE, STOCK RETAINING

STEEL FS.1022 OR FSB III/2 FED SPEC QQ-S-633

FINISH 125

MANUFACTURING COMPONENT

NOTE - ALTERNATIVE DESIGN.  
THE .041 X .041 BRAZING WIRE  
GROOVE ELIMINATED. 30 X 45° CHAMFER  
AT ONE END OF THE INTERIOR DIAMETER.  
OTHERWISE SAME AS STANDARD.  
TOLERANCE ±.01 ALLOWED ON ALL DIMEN-  
SIONS UNLESS OTHERWISE SPECIFIED.

SCALE 2

DWG 87266102 APPLIES

A-152882

A-152882

DR.G. PERTAINS TO  
51-102 30 BAR-M1918-A2  
661290 SLEEVE, STOCK  
C336423 RETAINING, ASM

DO NOT INSCRIBE PART NO.

DTSMAN TRACER LDR. DTSMAN  
7-7-40 7-7-40 6-8-40  
CHECKER 6-8-40 6-8-40 6-8-40  
SUBMITTED: 7-7-40 7-7-40 7-7-40  
APPROVED BY ORDER OF THE  
CHIEF OF THE  
ORDNANCE DEPT. U.S.A.

SUPERSEDES A152882

NOTICE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

HEAT TREATMENT & FINAL FINISH  
CARBURIZE AT 1550°F. .012 DEPTH OF CASE. QUENCH IN OIL. TEMPER AT 650°F.  
PROT. FINISH: FOR FS1117, TYPE I SPEC  
MIL-C-16232

~~DO~~ INSCRIBE PART NO.  
DONOT

PHYSICAL PROPERTIES

MAY 1, 1929

REVISIONS

Y. P.	1	6-1-36	6 <sup>2</sup>	1-21-44
T. S.	2 <sup>2</sup>	4-15-38	7 <sup>1</sup>	4-15-44
EL-2	3 <sup>3</sup>	6-1-39	8 <sup>2</sup>	1-28-49
RED.	4 <sup>2</sup>	4-10-42	9 <sup>1</sup>	9 JUNE 55
HT. T.	5 <sup>4</sup>	11-19-43	10 <sup>5</sup>	19 AUG 55

DRG. PERTAINS TO

BR. 51 13 30 BAR. M18

SCL. 9

C. C. 3 F7265703 30 BAR-M18 A2

ROCK. D56-61

SYMBOL

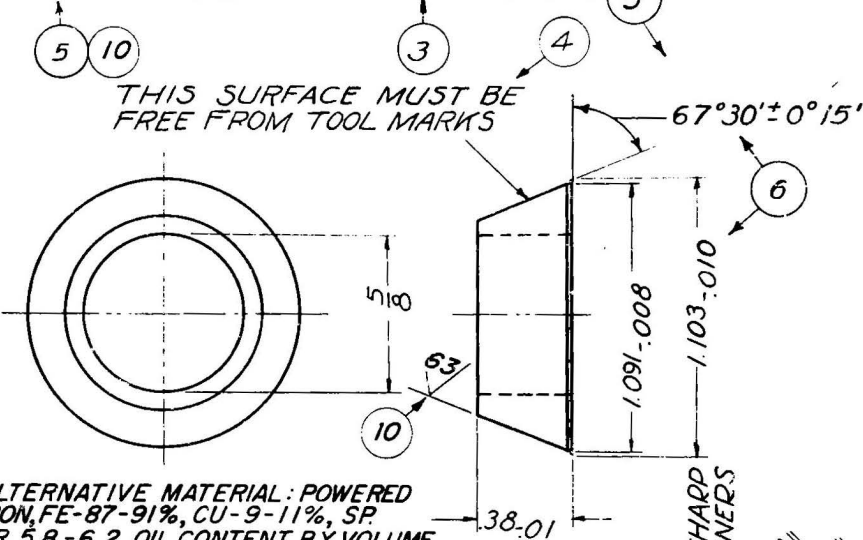
GGC 22

D'FTSMAN E.L.J.	TRACER J.A.	L'D.G. D'FTSMAN O.G.C.
CHECKER L.S.B.	CHIEF D'FTSMAN J.A.	CHIEF D'FTSMAN M.K.S.

SUBMITTED:  
CAPT. ORD. DEPT. U.S.A.

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:  
S.P.S. Spaldy  
LT. COL. ORD. DEPT. U.S.A.

ORDNANCE DEPT. U.S.A.



ALTERNATIVE MATERIAL: POWERED IRON, FE-87-91%, CU-9-11%, SP GR. 5.8-6.2, OIL CONTENT BY VOLUME 20% MIN. T.S. 25,000 P.S.I. MIN.-C.S. 120,000 P.S.I. MIN.

CONE, FRICTION, BUFFER A22217

STEEL FED SPEC QQ-S-633: FS 1117

ALL OVER EXCEPT AS NOTED

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SUPERSEDES OLD TRACING A22217

UNDER REVISION DATE OF JUNE 1, 1936

DWG B7266102 APPLIES

5022217

A5022217

A22217

SUPERSEDES A22217

A5022217

8

7

6

5

4

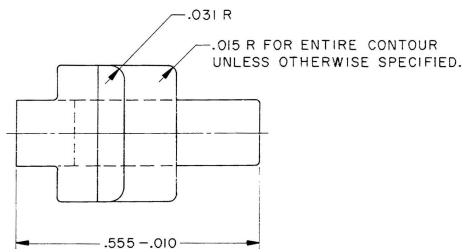
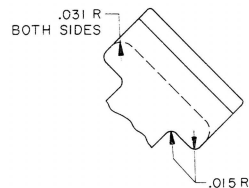
3

2

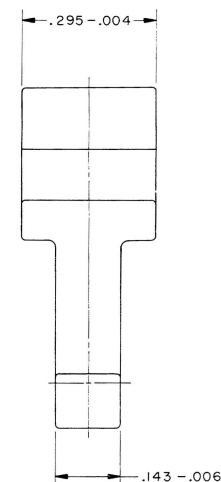
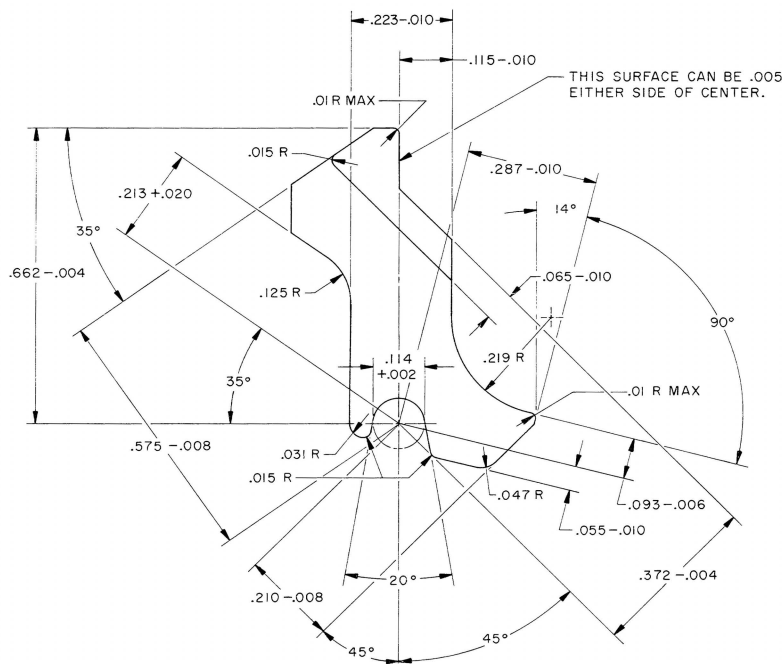
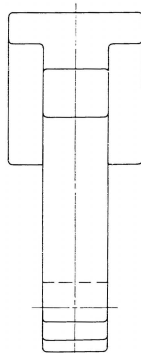
1

## NOTES:

1. FINISH ALL OVER  $\sqrt{125}$ .
2. ALL EDGES SHALL BE BROKEN  $.003 \pm .012$  UNLESS OTHERWISE SPECIFIED.
3. MATERIAL:  
STEEL, COMP 1095, SPEC QQ-S-631 OR SPEC QQ-S-634.
4. HEAT TREATMENT:  
HEAT AT 1450° TO 1475° F. OIL QUENCH.  
TEMPER 30 MINUTES TO ROCKWELL  
SPECIFIED. HEAT TREATMENT METHOD  
IS FOR GUIDANCE ONLY EXCEPT TEMPERING TIME  
SHALL NOT BE REDUCED BELOW THAT  
SPECIFIED.
5. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.



REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
	A		REDRAWN & REVISED W/CHANGE SEE ED R1A-14488	25 JAN 68



PART NO. 6019636

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 MAY 1929		DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 61201	
YP		TOLERANCES UNLESS OTHERWISE SPECIFIED		DRAWN BY	ELJ	CHECKED	LSC
TS		ANGLES 1°	XX ± .015	TRACED BY	ELJ	CHECKED	ELJ
EL 2		MATERIAL	SEE NOTE 3	ENGINEER	TJC	ENGINEER	EJA
RA		HEAT TREATMENT	SEE NOTE 4	SUBMITTED	Philip C. Hebeke		
BH	F6535469 .30 B.A.R.	FINAL PROTECTIVE FINISH	SEE NOTE 5	APPROVED	R. B. Henry		
RH	C45-55	APPLICATION		DWG SIZE	D	CODE IDENT NO.	6019636
		SCALE	8/1	UNIT	WT	SHEET	1 OF 1

REDUCED SIZE PRINT

NOTICE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

# HEAT TREATMENT & FINAL FINISH

ALTERNATIVE MATERIAL: POWDERED METAL: CU 86-89%, SN 9-10%, GRAPHITE 1-1.75%, SP GR. 6.8-7.2, OIL CONTENT BY VOLUME 10% MIN., TS 15,000 P.S.I. MIN., C.S. 60,000 P.S.I. MIN.

~~DO~~ INSCRIBE PART NO.  
DO NOT

REVISIONS  
11, 19 AUG 55

## PHYSICAL PROPERTIES

Y. P.  
T. S.  
EL-2  
RED.  
HT. T.

MAY 1, 1929

## REVISIONS

1	6-1-36	6	3-23-43
2	4-15-38	7	11-19-43
3	6-1-39	8	4-15-44
4	4-10-42	9	1-28-49
5	2-12-43	10	9 JUNE 55

## DRG. PERTAINS TO

BR.

5113 .30 BAR-M18

SCL

C. C.

F7265703 .30 BAR-M1918 A2

## SYMBOL

FDC 28

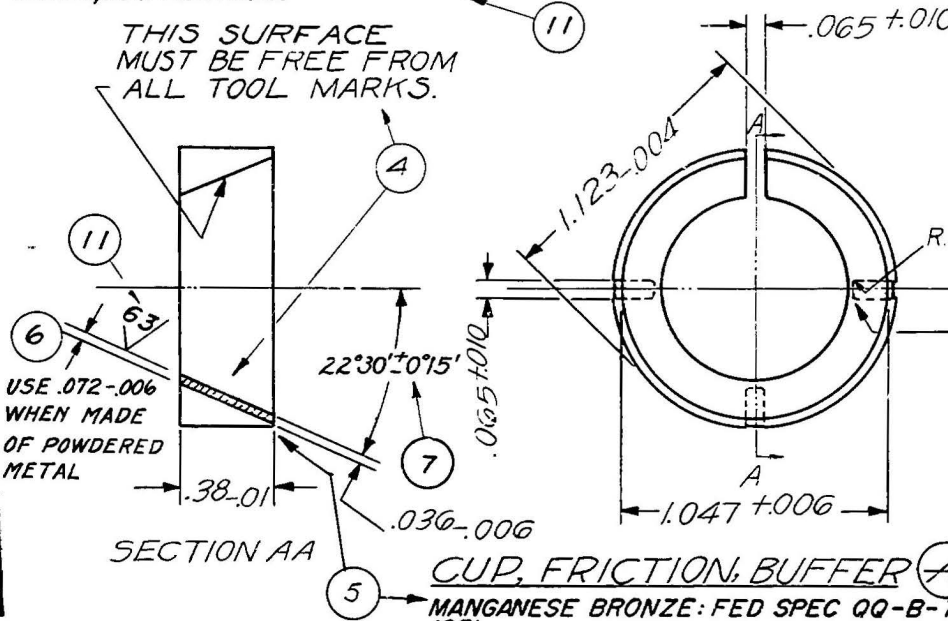
D'FTSMAN E. L. J.	TRACER J. J. D.	L'D'G D'FTSMAN O. J. C.
CHECKER J. J. D.	CHEF D'FTSMAN C. J. D.	

SUBMITTED

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:  
S. I. S.  
LT. COL., ORD. DEPT. U.S.A.

ORDNANCE DEPT. U.S.A.

THIS SURFACE MUST BE FREE FROM ALL TOOL MARKS.



CUP, FRICTION BUFFER A 22218-7

MANGANESE BRONZE: FED SPEC QQ-B-721

125/ ALL OVER EXCEPT AS NOTED

DWG B7266102 APPLIES

A5022218

A 22218

TOLERANCE ± .01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.  
SUPERSEDES OLD TRACING A 22218  
UNDER REVISION DATE OF JUNE 1, 1936 SCALE 2/7

2-2-194

SUPERSEDES A22218

A5022218

# LIST OF COMPONENTS

1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NO. REQUIRED
1	C 7267819	CYLINDER, GAS, ASSEMBLY	(1)
2		COMPOSED OF :	
3	D 7267818	1 - BODY, GAS CYLINDER	
4	C 7267815	1 - KEY, BODY	
5	C 7267816	1 - REGULATOR, GAS CYLINDER, ASSEMBLY	

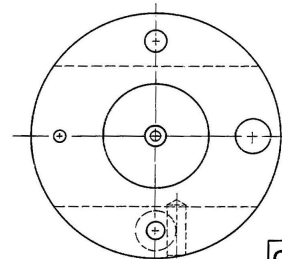
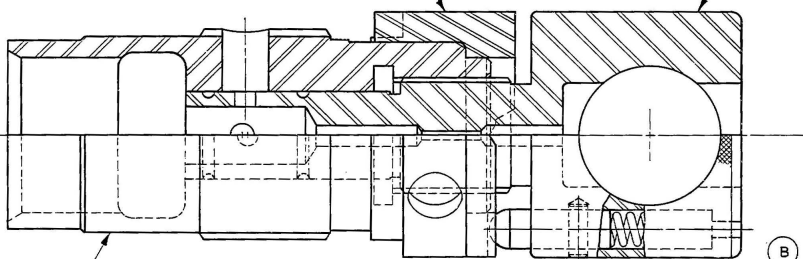
## NOTES:

1. MIL - W - 13855 APPLIES.

KEY - 7267815

REGULATOR ASSEMBLY - 7267816

BODY - 7267818



NOTES: THIS DRAWING SHALL NOT BE USED OR REPRODUCED ENTIRE WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT

CODE IDENT NO. 19204

PART NO. 7267819

SEE PL - 7267819

PHYSICAL PROPERTIES	APPLICATION	HEAT TREATMENT	FINAL PROTECTIVE FINISH
YP			
TS			
EL 2	F7265703	30BAR, M1918A2	
RA			
BH			
RH			
	DO NOT		
	APPLY PART NO.		
	AS SPECIFIED		

TOLERANCES ON	DECIMALS	FRACTIONS
ANGLES		
MATERIAL		
HEAT TREATMENT		
FINAL PROTECTIVE FINISH		

ORIGINAL DATE OF DRAWING	27 MAY 1955
DRAFTSMAN	CHECKER
TRACER	CHECKER
ENGINEER	ENGINEER
SUBMITTED	
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE	
LT COL	
ORD CORPS	

CYLINDER, GAS, ASSEMBLY

DEPT OF THE ARMY  
ROCK ISLAND ARSENAL  
ROCK ISLAND, ILL. 61201

DWG SIZE  
7267819

C SHEET 1 OF 1

SCALE 4/1 UNIT WT .16

7-APPLY IDENTITY "19200-9350010". MIL-STD-130 APPLIES.

3617680018 REV 03 / 10-05-83

7267146

AT A RANGE OF 100 YARDS (OR AT THE OPTION OF THE CONTRACTOR AT A RANGE OF 30 YARDS USING THE PRESCRIBED DIAGRAM) USING U.S. GOVERNMENT, CALIBER .30, STANDARD SERVICE AMMUNITION OF KNOWN ACCURACY, EACH RIFLE SHALL MEET THE FOLLOWING REQUIREMENTS:

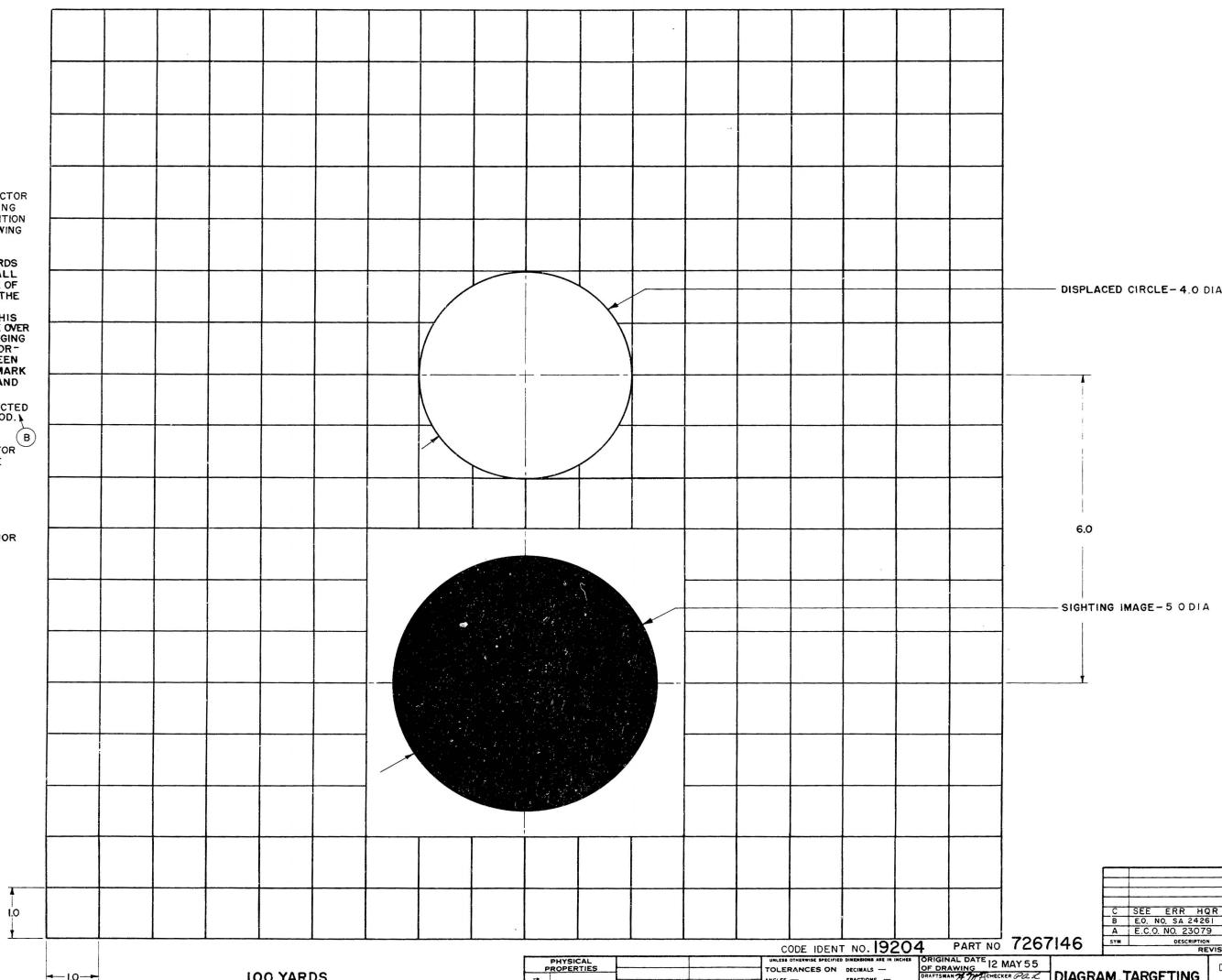
(A) WITH THE REAR SIGHT SET AT ZERO WINDAGE AND 300 YARDS ELEVATION, A 6 O'CLOCK HOLD ON THE SIGHTING IMAGE SHALL PLACE 5 CONSECUTIVE SHOTS WITHIN OR CUTTING THE EDGE OF THE DISPLACED CIRCLE, OR IT SHALL BE POSSIBLE TO MOVE THE GROUP WITHIN THE DISPLACED CIRCLE BY MOVEMENT OF THE FRONT SIGHT BLADE EITHER LEFT OR RIGHT, BUT LIMITING THIS MOVEMENT SO AS NOT TO CAUSE OVERHANGING OF THE BLADE OVER THE BASE. VERTICAL CORRECTIONS SHALL BE MADE BY CHANGING OR REWORKING THE FRONT SIGHT BLADE. AFTER SUITABLE CORRECTIONS FOR HORIZONTAL AND VERTICAL DEVIATION HAVE BEEN MADE THE FRONT SIGHT BLADE SHALL BE FIXED BY A PUNCH MARK AT THE JUNCTION OF THE BASE OF THE FRONT SIGHT BLADE AND THE TOP OF THE FRONT SIGHT BASE.

(B) ALL FIRING FOR TARGETING AND ACCURACY SHALL BE CONDUCTED WITH THE FLASH HIDER ASSEMBLED TO RIFLE, WITHOUT THE BIPOD.

(C) AT LEAST ONE PERCENT OF ALL RIFLES SHALL BE FIRED ON A 300 YARD RANGE, AFTER THEY HAVE BEEN ACCEPTED FOR TARGETING AND ACCURACY AS ABOVE, AND SHALL MEET THE REQUIREMENTS OF THE PRESCRIBED DIAGRAM.

FOUR WARMUP OR SIGHTING SHOTS WILL BE ALLOWED PRIOR TO TEST.

GRID LINES - OPTIONAL



D7267146

PHYSICAL PROPERTIES		TOLERANCES ON DECIMALS		ORIGINAL DATE 12 MAY 55	
1	AI2002930	1	1/100	1	OF DRAWING
2		2		2	CHECKED BY
3		3		3	CHECKER 232.2
4		4		4	TRACER
5		5		5	CHECKER 232.2
6		6		6	ENL. N. 12.5
7		7		7	UNION
8		8		8	UNION
9		9		9	UNION
10		10		10	UNION
11		11		11	UNION
12		12		12	UNION
13		13		13	UNION
14		14		14	UNION
15		15		15	UNION
16		16		16	UNION
17		17		17	UNION
18		18		18	UNION
19		19		19	UNION
20		20		20	UNION
DO NOT		APPLY PART NO.		FINAL PROTECTIVE FINISH	
DO NOT		APPLY PART NO.		FINAL PROTECTIVE FINISH	

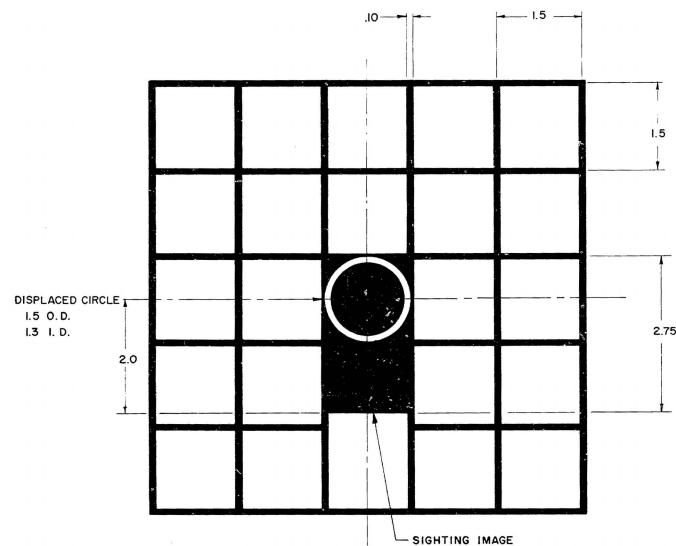
DIAGRAM, TARGETING AND ACCURACY

DEPT OF THE ARMY  
ROCK ISLAND ARSENAL  
ROCK ISLAND, ILL. 61201

7267146

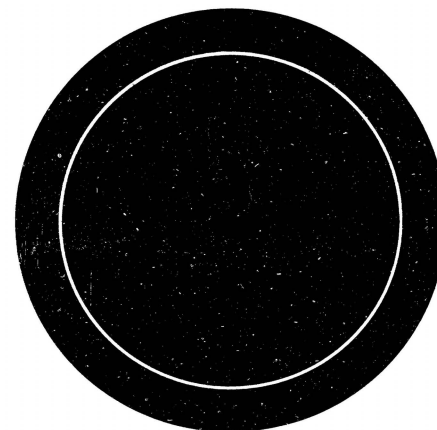
SHEET 1 OF 2





**30 YARDS**

GRID LINES—OPTIONAL



300 YARDS

WITH 300 YARDS SIGHT SETTING AND A 6 O'CLOCK HOLD ON A 15 INCH BULL'S-EYE, 10 ROUNDS SHALL BE FIRED. ALL SHOTS SHALL BE WITHIN OR CUTTING THE EDGE OF THE BULL'S-EYE AND 70 PERCENT OF THE SHOTS SHALL BE WITHIN A 12 INCH CIRCLE DRAWN CONCENTRIC WITH THE 15 INCH BULL'S-EYE.

D 7267146

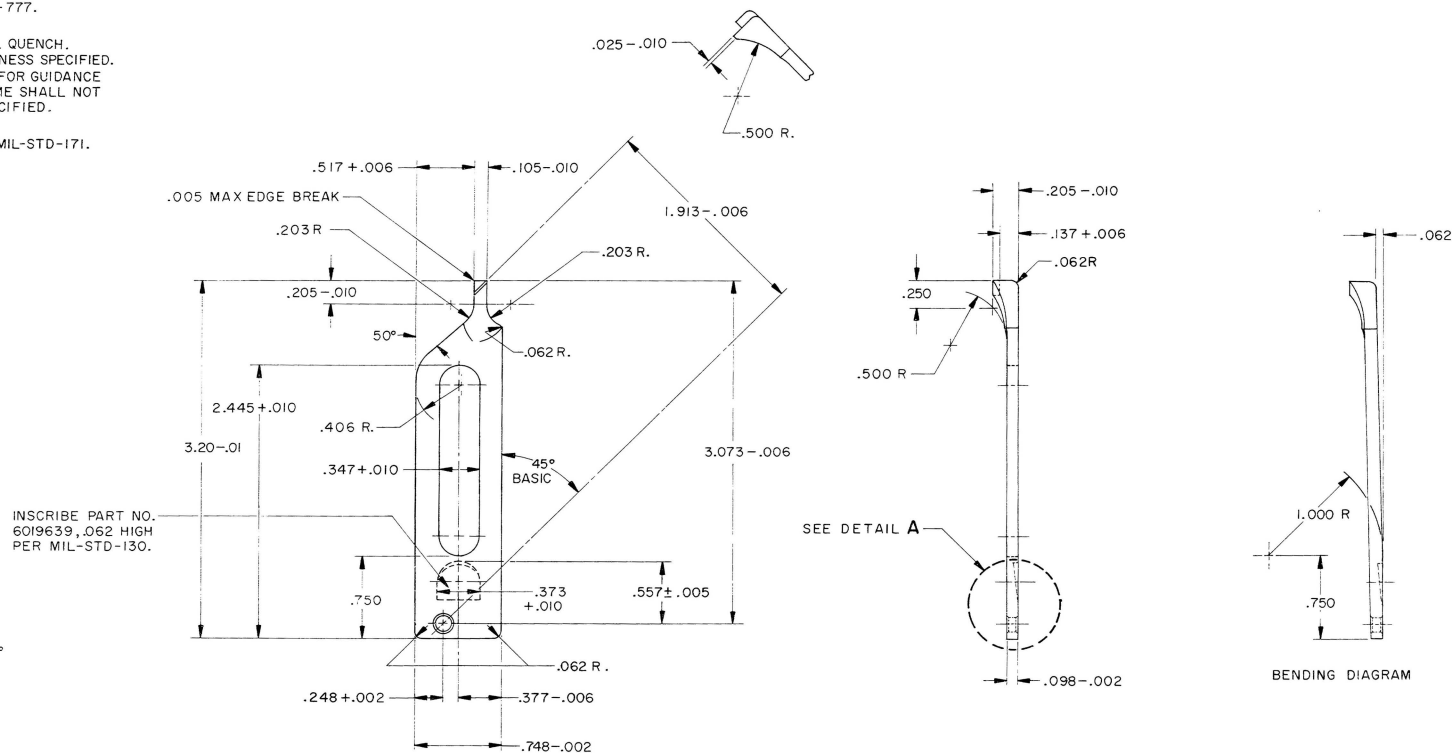
CODE IDENT NO. 19204  
PART NO. 7267146

C	SEE ERR HQR 30633	23 FEB 73	8045
B	E.O. NO. SA 24261	27 AUG 57	K. H. Hance
A	E.C.O. NO. 23079	19 AUG 55	
STW	DESCRIPTION	DATE	APPROVAL
	REVISIONS		

PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 12 MAY 1955		REVISIONS	
TP		TOLERANCES ON DECIMALS —		APPROVED BY: <i>[Signature]</i> CHECKER: <i>[Signature]</i> DRAWN BY: <i>[Signature]</i>		DEPT OF THE ARMY	
TS		FRACTIONS —		CHECKER: <i>[Signature]</i> MATERIAL:		ROCK ISLAND ARSENAL	
EL				SPECIAL: <i>[Signature]</i> SUPERVISOR: <i>[Signature]</i>		ROCK ISLAND, ILL. 61201	
RA				SLIP/OMITTED <i>[Signature]</i>			
SH		HEAT TREATMENT		ONE COPIES APPROVED BY ORDER OF: <i>[Signature]</i> LT COL AND CORPS		DWS D 726717 3 14	
NEXT ASSY USED APPLICATION		FIN. PROTECTIVE FINISH		SCALE: NONE LIMIT: WT			
DO NOT APPLY PART NO.							
G-0-46-GREASED-							

- NOTES: 125/  
 1. FINISH  $\sqrt{\text{X}}$  ALL OVER.  
 2. ALL EDGES SHALL BE BROKEN  
 .003+.012 UNLESS OTHERWISE  
 SPECIFIED.  
 3. MATERIAL:  
 STEEL, COMP 1095, SPEC QQ-S-777.  
 4. HEAT TREATMENT:  
 HEAT AT 1425° TO 1450° F. OIL QUENCH.  
 TEMPER 30 MINUTES TO HARDNESS SPECIFIED.  
 HEAT TREATMENT METHOD IS FOR GUIDANCE  
 ONLY EXCEPT TEMPERING TIME SHALL NOT  
 BE REDUCED BELOW THAT SPECIFIED.  
 5. FINAL PROTECTIVE FINISH:  
 FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.

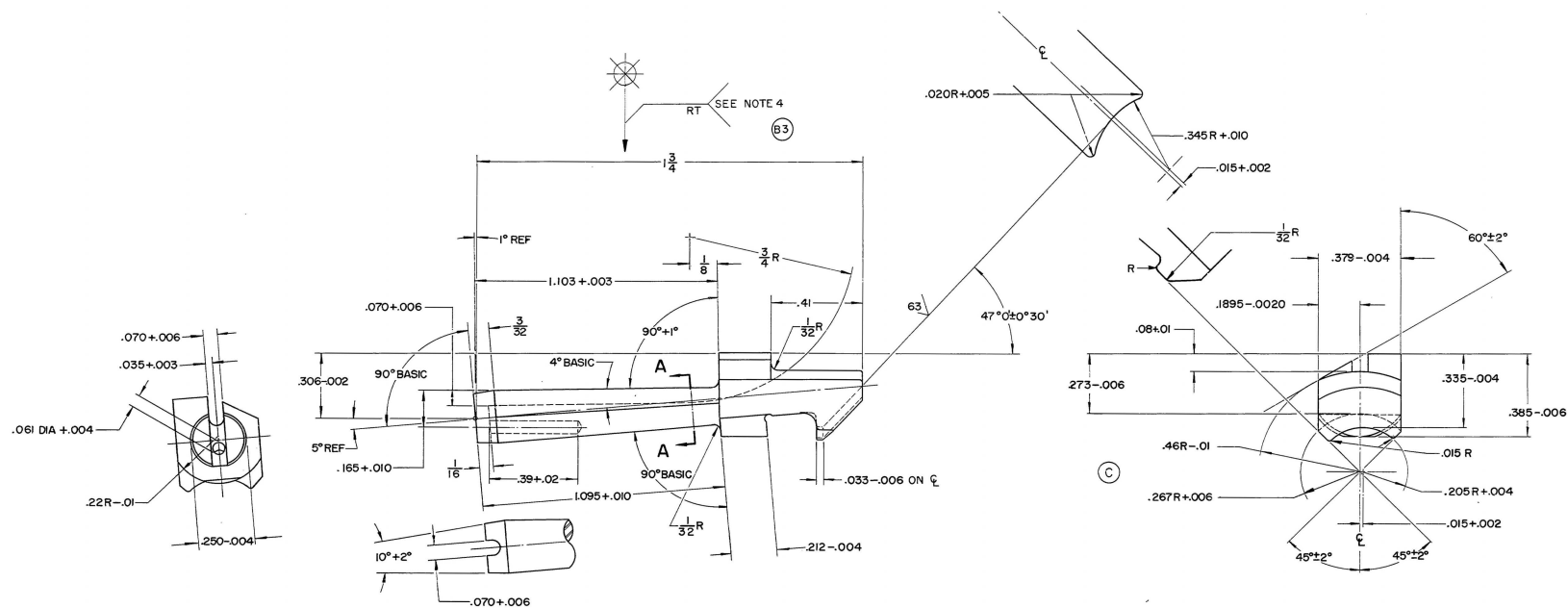
REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	REDRAWN & REVISED W/CHANGE SEE ED 71A-14488	25 JAN 68



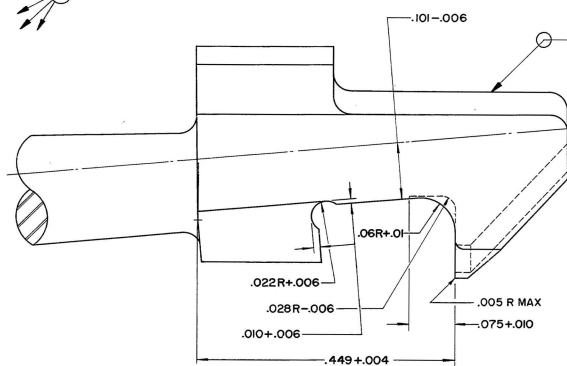
DETAIL - A  
 SCALE - 4/1

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 MAY 1929		PART NO. 6019639	
YP		TOLERANCES ON DIMENSIONS	XX ±	DRAWN BY	E.L.J.	CHECKED	L.S.C.
TS		ANGLES ± 1°	XXX ± .015	TITLE	W. H. H. H.	CHECKED	E.L.C.
EL 2		SEE NOTE 3		DESIGNED	T.J.C.	ENGINEER	E.J.A.
RA		HEAT TREATMENT		SUBMITTED			
BH	F6535469	.30 B.A.R.		APPROVED			
RH	C45-55	M1918 A2		R. S. Henry			
APPLICATION		FINAL PROTECTIVE FINISH		SEE NOTE 5			
NEXT ASSY.		USED ON		DWG SIZE			
				D 19204			
				CODE IDENT NO.			
				6019639			
				SCALE 2/1			
				UNIT INT			
				SHEET 1 OF 1			

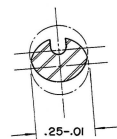
REDUCED SIZE PRINT



1. 125 ALL OVER EXCEPT AS NOTED.
2. CORNERS AND EDGES SHALL BE BROKEN .005+ .010 UNLESS OTHERWISE SPECIFIED AND SHALL BE FREE FROM BURRS.
3. FOR PRECISION CASTING:  
CASTING TO MEET THE REQUIREMENTS OF  
COMP TC-1050, SPEC MIL-S-22141.
4. CLASSIFICATION AND INSPECTION OF INVESTMENT CASTINGS TO BE IN ACCORDANCE WITH CLASS IB, GRADE B, SPEC MIL-C-6021.
5. FINAL HEAT TREATMENT:  
HEAT TO 1550°F - 1000°F QUENCH IN  
CIRCULATING OIL TEMPER 30 MINUTES AT  
HEAT TO HARDNESS SPECIFIED. HEAT  
TREATMENT METHOD IS FOR GUIDANCE ONLY  
EXCEPT THAT TEMPERING TIME SHALL NOT  
BE REDUCED BELOW THAT SPECIFIED.



EXTRACTOR HEAD  
SCALE  $\frac{10}{1}$



SECTION A-A

D 5509090 B



CODE IDENT NO. 19204  
PART NO. 5509090

C	(1)SEE EO HRD 92055	16APR85	<i>W</i>
B	(1-4) SEE EO 82151	25JUN86	<i>W</i>
A	REDRAWN AND REVISED WAS	28OCT86	<i>W</i>
	C" SIZE E.O. 5422987		
14		19AG 55	
SYN	DESCRIPTION	DATE	APPROVAL
REVISONS			
<p>DEPT OF THE ARMY</p> <p>ROCK ISLAND ARSENAL</p> <p>ROCK ISLAND, ILL. 61201</p>			
<p>EXTRACTOR</p>		<p>DWG SIZE</p>	<p>550909</p>
4.1	UNIT NO. 02	<p>PART</p>	<p>OF</p>

PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED, CONSTRUCTION AND FINISH		ORIGINAL DATE 1 MAY 29	
F 7265703 30BAR M918		TOLERANCES ON DECIMALS: .01		OF DRAWING	
12	A2	ANGLES: 1/16 FINISHES: 1/64		DRAWN BY L.V. CHECKED BY S	
13	SEE ENGINEERING RECORDS	MATERIAL: STEEL, COMP 1095, SPEC QCS-531		INCHES: 1/8 CHECKED BY S	
14		HEAT TREATMENT		SUBMITTED	
15	NEXT ASST USED ON	SEE NOTE 5		BY J. J. Gorman	
APPLICATION		FINAL PROTECTIVE FINISH		APPROVED BY ORDER OF THE	
16	C45-55	DO NOT APPLY PART NO.		5.3.2 OF MIL-STD-171	
17	DO NOT	5.3.2 OF MIL-STD-171		BY J. J. Gorman	



NOTES:

- 5

A

SWESP 1177-1  
28 AUG 62

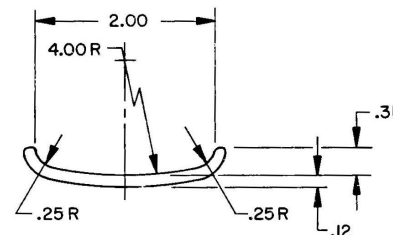
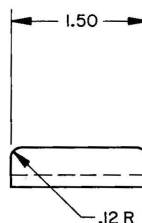
NOTES:

1. FINISH ALL OVER  $\sqrt{125}$ .

2. MATERIAL:

STEEL, COMP 1020, SPEC QQ-S-631  
OR SPEC QQ-S-634.

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	REDRAWN & REVISED W/CHG SEE EO 82075	8 APR 68



PART NO. 5152772

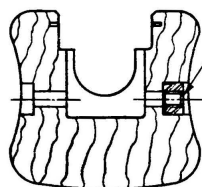
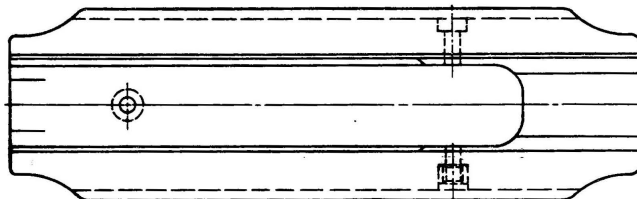
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 JUNE 1939		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON DECIMALS XX ± .01		DRAFTSMAN EJR	CHECKER LSC	FOOT, BIPOD	
TS		ANGLES ± XXX ±		TRACER Box 8. Gankill	CHECKER R. Wilson		
EL 2		MATERIAL SEE NOTE 2		ENGINEER R. S. Henry	ENGINEER P. Heberle		
RA	C 7312236	.30 BAR-M18A2	HEAT TREATMENT	SUBMITTED Philip E. Heberle		DWG SIZE B	CODE IDENT NO. 19204
BH	B 7312237	.30 BMG-M19A6	FINAL PROTECTIVE FINISH	APPROVED R. S. Henry		5152772	
RH	APPLICATION		SCALE 1/1 UNIT WT SHEET 1 OF 1				

SWERL FORM 40B. 1 MAR 67

NOTES: 1. WHEN GOVERNMENT DRAWINGS, SPECIFICATIONS, OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT THEREBY INCURS NO LIABILITY FOR ANY OBLIGATION WHATSOEVER, AND THE FACT THAT THE GOVERNMENT MAY HAVE CONSULTED, FURNISHED, OR IN ANY WAY SUPPLIED THE SAID DRAWINGS, SPECIFICATIONS, OR OTHER DATA IS NOT TO BE REGARDED BY IMPLICATION OR OTHERWISE AS IN ANY MANNER LICENSES THE HOLDER OR ANY OTHER PERSON OR CORPORATION, OR CONFERS ANY RIGHTS OR PERMISSION TO MANUFACTURE, USE, OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE RELATED THERETO.

## NOTES:

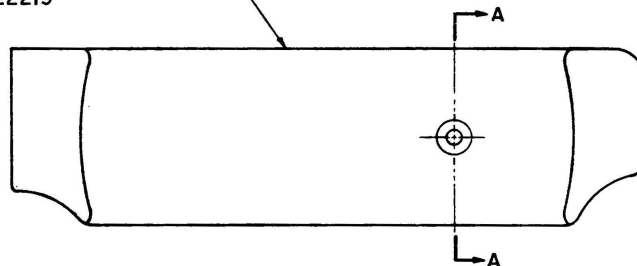
1. DWG B7266102 APPLIES.
2. FOR STAMPING OF PART NUMBER (5564206) SEE DRAWING 5564205.



SECTION A-A

ESCUTCHEON - 5022219

FOREARM - 5564205



C5564206

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 5564206

ORD PART NO. 5564206

PHYSICAL PROPERTIES		F 7265703 .30 BAR		TOLERANCES ON DECIMALS		ORIGINAL DATE OF DRAWING 1 JUN 39		FOREARM ASSEMBLY		SPRINGFIELD ARMORY ORDNANCE CORPS DEPT OF THE ARMY SPRINGFIELD 1, MASS.	
M1918 A2		MATERIAL		FRACTIONS		DRAFTSMAN C.H.C.					
SEE ENGINEERING RECORDS		HEAT TREATMENT		CHECKER		CHECKER					
NEXT ASSY USED ON		FINAL PROTECTIVE FINISH		ENGINEER		ENGINEER					
APPLICATION		APPLY PART NO. 5564206 PER MIL-STD-130, SEE NOTE 2 AS SPECIFIED		APPROVED BY ORDER OF THE CHIEF OF ARMORY		SUBMITTED		DATE		REVISIONS	
						R.D. Henry		19 DEC 50		A REDRAWN AND REVISED	
						ORD CORPS		9 JUN 55		SEE E.O. SA24481	
						ORD CORPS		DATE		DESCRIPTION	
						SCALE 1/1		UNIT WT. 43 LB		C 5564206	

C 5564206

B

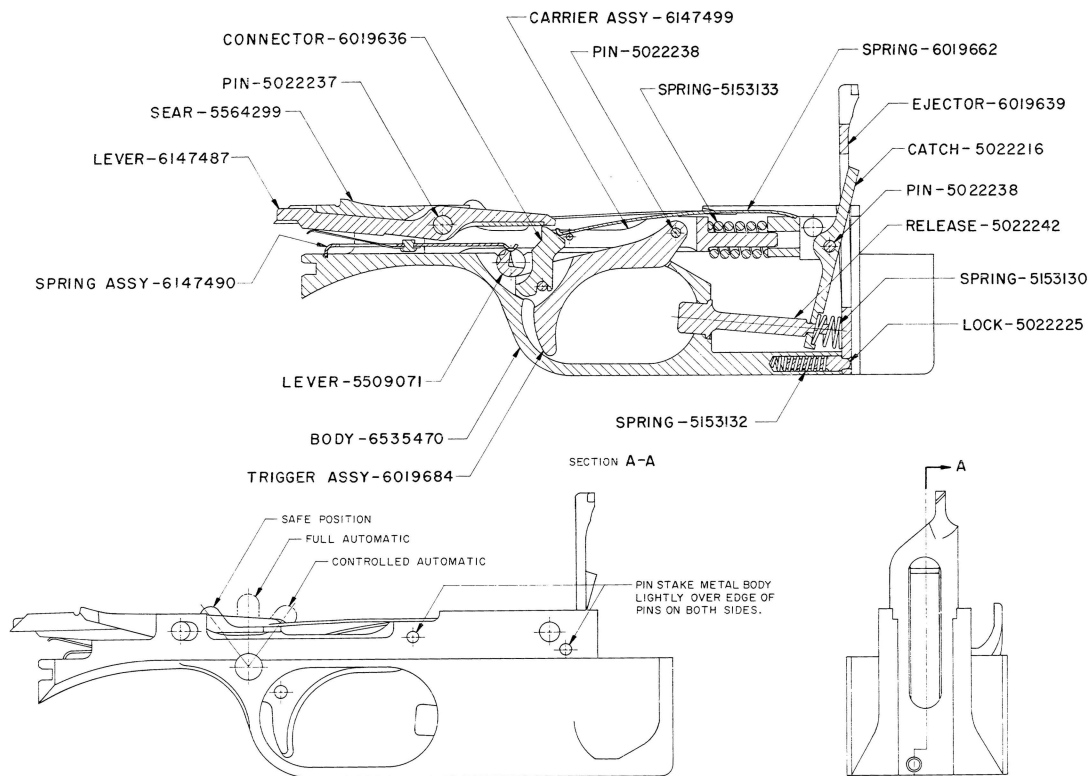
A

A

SCALE	1/1	UNIT WT 43 LB
-------	-----	---------------



NOTE:  
1. TOUCH UP IN ACCORDANCE WITH  
DRAW'NG C7792281.



REVISIONS		
NO.	DESCRIPTION	DATE
1	REDRAWN & REVISED W/CHANGE SEE ED RIA-1A488	25 JAN 68

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 6535469		PART NO. 6535469	
MECHANICAL PROPERTIES		ORIGINAL DATE 5 JUN 1940	
DIMENSIONS ARE IN INCHES		ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 61201	
UNLESS OTHERWISE SPECIFIED		C.K.M. C.H.C.	
ANGLES & TOLERANCES ON "TRIM" & "FINISH"		C.J.T. E.J.A.	
MATERIAL		EJECTOR	
TREATMENT		EJECTOR	
F7265703 .30 B.A.R.		EJECTOR	
1918A2		EJECTOR	
HEAT ASSY. USED ON		EJECTOR	
APPLICATION		EJECTOR	
FIRE PROTECTIVE FINISH		EJECTOR	
APPROVED		EJECTOR	
SCALE 2/1		EJECTOR	
UNIT WT.		EJECTOR	
SHEET		EJECTOR	

REDUCED SIZE PRINT

1. THIS DRAWING SHALL BE USED AS A SUPPLEMENT TO DRAWINGS OF COMPONENTS WHICH WILL BE MANUFACTURED BY THE PRECISION CASTING PROCESSES. SHOULD ANY CONFLICT EXIST WITH REQUIREMENTS SPECIFIED IN MIL-C-10005, THE DRAWING SHALL TAKE PRECEDENCE.

#### II. GENERAL

A. MASTER HEAT AND MELT DEFINITIONS  
A MASTER HEAT IS THE PRODUCT OF A SINGLE FURNACE CHARGE. AN INDIVIDUAL PRODUCTION MELT IS THE RESULT OF REMELTING A PORTION OF THE MASTER HEAT. IF ALLOYING ELEMENTS OTHER THAN THOSE REQUIRED FOR CARBURIZING AND DEOXIDIZING ARE ADDED TO THE INDIVIDUAL MELTS, THESE MELTS SHALL BE CONSIDERED AS INDIVIDUAL MASTER HEATS.

B. IDENTIFICATION AND LOT NUMBER DEFINITIONS  
1. CASTINGS MADE FROM AN INDIVIDUAL MELT SHALL BE PROPERLY IDENTIFIED BY MELT NUMBERS. CASTINGS SHALL RETAIN IDENTITY WITH THEIR RESPECTIVE MASTER HEATS OR INDIVIDUAL PRODUCTION MELTS, AS APPLICABLE, UNTIL SUCH TIME AS THE CASTINGS ARE ACCEPTED BY THE GOVERNMENT INSPECTOR. UPON SATISFACTORY COMPLETION OF COMPOSITION TESTS:

(A) A LOT SHALL CONSIST OF CASTINGS WHICH ARE THE PRODUCT OF AN INDIVIDUAL PRODUCTION MELT OR A GROUP OF PRODUCTION MELTS. THE NUMBER OF MELTS USED TO FORM A LOT SHALL BE GOVERNED BY THE NUMBER OF MELTS INDICATED FOR THE RESPECTIVE SCHEDULES IN PARAGRAPH III, B, 2, (A). NOT MORE THAN ONE MASTER HEAT SHALL BE REPRESENTED IN ANY ONE LOT.

(B) ALL CASTINGS WHICH ARE POURED DIRECTLY FROM A MASTER HEAT SHALL BE IDENTIFIED AS A LOT.

(C) LOT NUMBER IDENTITY SHALL BE RETAINED THROUGH GOVERNMENT INSPECTION.

#### III. CHEMICAL ANALYSIS TESTS

A. TEST SPECIMENS - CHEMICAL COMPOSITION TESTS AS SPECIFIED IN PARAGRAPH III, B, SHALL BE MADE ON A REPRESENTATIVE TEST SPECIMEN (FIG. A), CASTING, OR A SOUND PORTION OF THE SPRUE. DECARBURIZED SURFACES SHALL BE REMOVED IN THE PREPARATION OF SAMPLES FOR ANALYSIS. SPECIMENS FOR TEST PURPOSES MAY BE SELECTED BY THE INSPECTOR.

B. REQUIRED TESTS - CHEMICAL ANALYSIS TESTS SHALL BE CONDUCTED AS FOLLOWS:  
1. COMPLETE CHEMICAL ANALYSIS SHALL BE MADE OF EACH MASTER HEAT. THE RESULT OF THIS ANALYSIS SHALL BE SUCH AS TO PRODUCE CASTINGS WHOSE COMPOSITION IS WITHIN THE PRESCRIBED REQUIREMENTS. WHERE COMPONENT CASTINGS ARE POURED DIRECTLY FROM THE MASTER HEAT, THE COMPOSITION OF THE CASTINGS ANALYSIS MUST COMPLY WITH THE DRAWING REQUIREMENTS.

#### 2. INDIVIDUAL PRODUCTION MELTS:

(A) WHEN INDIVIDUAL PRODUCTION MELTS FROM A MASTER HEAT ARE USED FOR CASTING, TESTS SHALL BE CONDUCTED ON TEST SPECIMENS (PAR. IIIA).

UNLESS OTHERWISE SPECIFIED, THE FOLLOWING SCHEDULES SHALL APPLY:

SCHEDULE	SAMPLES REQUIRED	CHEMICAL ANALYSIS REQUIRED
A	1 OUT OF EACH INDIVIDUAL PRODUCTION MELT FOR 10 CONSECUTIVE MELTS.	COMPLETE
B	1 OUT OF EACH GROUP OF 50 SUCCESSIVE PRODUCTION MELTS.	APPLIES TO CARBON, MANGANESE, AND SILICON. UNLESS OTHERWISE SPECIFIED WITH SYMBOL *ON COMPONENT DRAWING

THE TESTS REQUIRED IN THESE SCHEDULES SHALL BE CONDUCTED IN ALPHABETICAL SEQUENCE AND TESTS OF SPECIMENS FOR EACH REQUIRED SCHEDULE MUST BE SATISFACTORILY COMPLETED PRIOR TO UNDERTAKING THE NEXT TEST ON THE SPECIFIED SCHEDULE. WHEN ONLY ONE OF SCHEDULES A, OR B, IS PRESCRIBED, THE TESTS REQUIRED FOR THAT SCHEDULE SHALL BE CONTINUED FOR THE DURATION OF THE ORDER. WHEN MORE THAN ONE OF THE SCHEDULES IS PRESCRIBED, THE TESTS REQUIRED FOR THE LATTER SCHEDULE SHALL BE CONTINUED FOR THE DURATION OF THE ORDER.

(B) IN THE EVENT AN ANALYSIS OF AN INDIVIDUAL MELT OF SCHEDULE B DOES NOT MEET COMPOSITION REQUIREMENTS AS SPECIFIED, THE CASTINGS OF THAT MELT SHALL BE REJECTED. AN ANALYSIS OF SPECIMENS FROM EACH OF TWO ADDITIONAL INDIVIDUAL MELTS IN THE SCHEDULE SHALL THEN BE MADE. A REJECT OF EITHER OF THESE LATTER TWO INDIVIDUAL MELTS WILL BE CAUSE FOR REJECTION OF ALL PRODUCTION MELTS IN THE LOT. EXCEPTION TO THIS MAY BE MADE WHEN THE CONTRACTOR SUBMITS AN ANALYSIS OF EACH OF THE REMAINING INDIVIDUAL MELTS WHICH INDICATES THAT THE CASTINGS PRODUCED FROM EACH OF THESE INDIVIDUAL MELTS ARE WITHIN THE COMPOSITION REQUIREMENTS. CASTINGS COMPLYING WITH THE SPECIFICATIONS MAY THEN BE ACCEPTED, PROVIDED THEY CONFORM WITH OTHER REQUIREMENTS.

(C) AFTER THE CONTRACTOR HAS DEVELOPED SATISFACTORY CONTROL METHODS TO COMPLY WITH SCHEDULE A, CHANGES WILL NOT BE ALLOWED WITHOUT THE APPROVAL OF THE CONTRACTING OFFICER. IN THE EVENT SUCH APPROVAL IS GRANTED, THE CONTRACTOR SHALL AGAIN FURNISH ANALYSIS OF CHEMICAL COMPOSITION IN ACCORDANCE WITH THE SCHEDULES OUTLINED IN PARAGRAPH III, B, 2, (A).

#### IV. HEAT TREATMENT

A. BEFORE FINAL HEAT TREATMENT, CASTINGS SHALL BE FULLY ANNEALED BY SOAKING FOR AN ADEQUATE LENGTH OF TIME AT A TEMPERATURE SUFFICIENTLY ABOVE THE CRITICAL TRANSFORMATION TEMPERATURE TO REFINE THE GRAIN STRUCTURE, FOLLOWED BY COOLING IN A MANNER WHICH WILL NOT CAUSE DECARBURIZATION OR DEVELOP DETRIMENTAL STRESSES IN THE CASTING.

B. UNLESS OTHERWISE SPECIFIED, THE MAXIMUM PERMISSIBLE DECARBURIZATION, PARTIAL PLUS TOTAL, SHALL NOT EXCEED .003 INCH IN FROM THE AS CAST SURFACES (IF THE FINAL COMPONENT HEAT TREATMENT PERMITS A DECARBURIZED SURFACE, IT SHALL BE THE SAME AS PERMITTED "AS CAST" AND NOT AN ACCUMULATIVE TOTAL). CARBON RESTORATION IS PERMITTED AND SHALL BE SO CONTROLLED THAT THE CARBON CONTENT OF THE RESTORED AREA SHALL BE WITHIN THE RANGE OF CARBON CONTENT SPECIFIED FOR THE CASTING. CARBON RESTORATION TREATMENT SHALL BE OF SUFFICIENT DURATION SO THAT NO LAYER OF DECARBURIZED MATERIAL EXISTS BETWEEN SURFACE AND CORE. ANNEALING AND CARBON RESTORATION MAY BE ACCOMPLISHED IN ONE OPERATION.

C. CASTINGS THAT WILL SUBSEQUENTLY BE CASE HARDENED DURING FINAL HEAT TREATMENT NEED NOT BE CARBON RESTORED PROVIDED THE DEPTH OF DECARBURIZATION DOES NOT EXCEED THE MINIMUM DEPTH OF CASE SPECIFIED FOR THE COMPONENT.

#### V. INITIAL PRODUCTION

AFTER THE CONTRACTOR HAS DEVELOPED PRODUCTION TECHNIQUES AND CONTROLS TO PRODUCE THE REQUIRED UNIFORM QUALITY LEVEL, HE SHALL FURNISH THE SPRINGFIELD ARMORY FIFTY SAMPLE CASTINGS, UNLESS OTHERWISE SPECIFIED, FOR APPROVAL. EACH CASTING SHALL BE NUMBERED FOR IDENTIFICATION. UPON APPROVAL, SAMPLE CASTINGS WHICH HAVE NOT BEEN DESTROYED MAY BE RETURNED UPON REQUEST BY THE CONTRACTOR FROM SPRINGFIELD ARMORY FOR USE AS STANDARDS FOR GENERAL WORKMANSHIP, APPEARANCE, FINISH, AND ALL OTHER QUALITIES FOR WHICH DEFINITE REQUIREMENTS AND TESTS ARE NOT PRESCRIBED.

#### VI. INSPECTION

A. INITIAL PRODUCTION  
SAMPLE CASTINGS (PAR. V) FROM THE INITIAL LOT SHALL BE SUBJECTED TO EXHAUSTIVE EXAMINATION TO DETERMINE THEIR OVERALL QUALITY. THIS MAY INCLUDE TENSILE, IMPACT, STATIC LOAD TESTS, HARDNESS, CHEMICAL ANALYSIS, SURFACE INSPECTION, RADIOGRAPHIC EXAMINATION, MAGNETIC PARTICLE (WET METHOD) AND PENETRANT INSPECTION OF THE CASTINGS. IN ADDITION, THE CASTING MAY BE SECTIONED FOR METALLOGRAPHIC STUDY FOR SOUNDNESS, CLEANLINESS, GRAIN SIZE AND STRUCTURE.

#### B. INSPECTION, GENERAL

1. THERE SHALL BE 100% VISUAL INSPECTION MADE ON ALL CASTINGS. AT THE DISCRETION OF THE CONTRACTING OFFICER, MINOR IMPERFECTIONS ON SURFACES OF THE CASTINGS MAY BE REMOVED BY MEANS OF MACHINING OR GRINDING, (PROVIDED THAT DIMENSIONAL REQUIREMENTS ARE MET).

2. PRIOR TO FINAL HEAT TREATMENT, THE EFFECTIVENESS OF THE CARBON RESTORATION TREATMENT SHALL BE CHECKED ON A REPRESENTATIVE SAMPLE (TWO CASTINGS) SELECTED AT RANDOM FROM EACH LOT OF CARBON RESTORED CASTINGS PROCESSED IN A SINGLE HEAT TREATING OPERATION. THE CASTINGS TO BE EXAMINED SHALL BE CUT AT RIGHT ANGLES TO THE OUTSIDE SURFACE. THE CUT SURFACE SHALL BE POLISHED, ETCHED WITH A 3 TO 5 PERCENT NITAL SOLUTION AND MICROSCOPICALLY EXAMINED AT A MAGNIFICATION OF NOT LESS THAN 500 POWER. THE PRESENCE OF DECARBURIZED OR CARBURIZED LAYERS ON THE CASTINGS (BEYOND THAT SPECIFIED IN PARAGRAPH IV B) SHALL BE CAUSE FOR REJECTION AND NECESSITATE CORRECTIVE ACTION. CRACKS AND THE PRESENCE OF GRAIN BOUNDARY OXIDES AT THE SURFACE SHALL BE CAUSE FOR REJECTIONS.

3. UNLESS OTHERWISE SPECIFIED, ALL CASTINGS SHALL BE SUBJECTED TO RADIOGRAPHIC INSPECTION BY THE CONTRACTOR OR AN APPROVED AGENT FOR THE CONTRACTOR. SOUNDNESS REQUIREMENTS SHALL BE IN ACCORDANCE WITH MIL-STD-2175. RADIOGRAPHIC FILM SHALL BE IN ACCORDANCE WITH FED SPEC L-F-350. TYPE AND CLASS OF FILM SELECTED SHALL BE SUITABLE FOR THE PURPOSE INTENDED.

#### VII. PHYSICAL AND MECHANICAL TESTS

A. EITHER A TEST BAR OR REPRESENTATIVE CASTING OF EACH INDIVIDUAL MELT SHALL BE BROKEN AND THE FRACTURE EXAMINED FOR SOUNDNESS AND EFFECTIVENESS OF MELTING CONTROL.

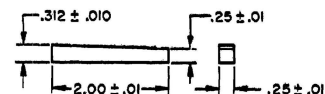
B. WHEN REQUIRED, OTHER PHYSICAL AND MECHANICAL TESTS SHALL BE CONDUCTED AS PRESCRIBED ON COMPONENT DRAWING.

#### VIII. QUALITY CONTROL

A. THE APPLICATION OF QUALITY CONTROL SAMPLING METHODS FOR SOUNDNESS SHALL BE IN ACCORDANCE WITH MIL-STD-1238.

#### IX. CHEMICAL COMPOSITION

UNLESS OTHERWISE SPECIFIED ON THE COMPONENT DRAWING, THE INDIVIDUAL DETERMINATIONS OF CHEMICAL COMPOSITIONS SHALL NOT VARY FROM THE RANGES AND LIMITS SPECIFIED IN FED. STD. NO. 66 BY MORE THAN THE CHECK ANALYSIS TOLERANCES APPLICABLE TO CROSS-SECTIONAL AREAS OF 100 SQUARE INCHES OR LESS.



TEST BAR  
(FIG. A)

FOR NEW DESIGN & PROCUREMENT  
USE MIL-S-22141

CURRENT DESIGN ACTIVITY CODE CODE 19200  
U.S. ARMY  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PART NO.

U.S. ARMY  
SPRINGFIELD ARMORY  
SPRINGFIELD, MASS. 01101

### GENERAL REQUIREMENTS FOR PRECISION CASTINGS

DWG. SIZE: CODE: IDENT. NO.  
D 19205 7267837

SCALE UNIT WT. SHEET 1 OF 1

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE 10 MAY 55 OF DRAWING	
YP		TOLERANCES ON DIMENSIONS - ANGLES		DRAFTSMAN CHECKED	
UT		FRACTIONS		TRACER CHECKED	
EL2		MATERIAL		DRAWN BY	
RA		HEAT TREATMENT		SUBMITTED	
BN	SEE ENGINEERING RECORDS			K. H. Henry	
RM	NEXT ASSY. USED ON	FINAL PROTECTIVE FINISH		C. J. Henderson	
APPLICATION				APPROVED	
EFFECT PART NO.				D	

DISTRIBUTION STATEMENT A.  
APPROVED FOR PUBLIC RELEASE;  
DISTRIBUTION IS UNLIMITED.

NOTICE: - PRELIMINARY DRAWING, SPECIFICATION, OR OTHER DATA ARE NOT FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT REQUIREMENT OPERATION. THE UNITED STATES GOVERNMENT THEREBY ASSUMES NO RESPONSIBILITY FOR ANY UNLAWFUL REPRODUCTION AND THE FACT THAT THE GOVERNMENT MAY HAVE COMPLETED, FORWARDED, OR IN ANY MANNER SUPPLIED THE SAME DRAWING, SPECIFICATION, OR OTHER DATA IS NOT TO BE CONSIDERED AN IMPLICATION OR ATTEMPT TO OBTAIN A GOVERNMENT LICENSE. THE HOLDER OR ANY OTHER PERSON OR CORPORATION, OR CONVEYING ANY RIGHTS OR PERMISSION TO REPRODUCE, USE, OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE RELATED THEREOF.

B7266102

15. MIL-STD-171 WITH THE APPLICABLE FINISH NO. SHALL APPLY FOR PHOSPHATE COATINGS, AND FOR BLACK OXIDE FINISHES IN LIEU OF ANY OTHER SPECIFICATION PRESCRIBED ON A DRAWING FOR WHICH THIS DRAWING B7266102 IS APPLICABLE. CONVERSION OF TYPES SHALL BE AS FOLLOWS:

## CONVERSION TABLE

## PHOSPHATE COATINGS:

FROM	TO
SPEC 57-0-2, TYPE II, CLASS A	FINISH NO. 5.3.1 OF MIL-STD-171
SPEC 57-0-2, TYPE II, CLASS B	FINISH NO. 5.3.3 OF MIL-STD-171
SPEC MIL-C-16232, TYPE I	FINISH NO. 5.3.1 OF MIL-STD-171
SPEC MIL-C-16232, TYPE II	FINISH NO. 5.3.3 OF MIL-STD-171
SPEC MIL-C-12968, TYPE A	FINISH NO. 5.3.1 OF MIL-STD-171
SPEC MIL-C-12968, TYPE B, CLASS 1	FINISH NO. 5.3.3 OF MIL-STD-171

WHEN FINISH NUMBERS SPECIFIED IN MIL-STD-171 REFER TO SPEC MIL-C-12968 SPEC MIL-P-16232 SHALL APPLY IN LIEU THEREOF.

## OXIDE COATINGS:

FROM	TO
SPEC 57-0-2, TYPE III, CLASS A, GRADE I	FINISH NO. 3.3.1.1 OF MIL-STD-171
SPEC 57-0-2, TYPE III, CLASS B	FINISH NO. 3.3.2 OF MIL-STD-171
SPEC 57-0-2, TYPE III, CLASS C	FINISH NO. 3.3.3 OF MIL-STD-171
SPEC MIL-F-13924, CLASS 1, GRADE A	FINISH NO. 3.3.1.1 OF MIL-STD-171
SPEC MIL-F-13924, CLASS 2	FINISH NO. 3.3.2 OF MIL-STD-171
SPEC MIL-F-13924, CLASS 3	FINISH NO. 3.3.3 OF MIL-STD-171
SPEC MIL-C-13924, CLASS 1	FINISH NO. 3.3.1 OF MIL-STD-171
SPEC MIL-C-13924, CLASS 2	FINISH NO. 3.3.2 OF MIL-STD-171
SPEC MIL-C-13924, CLASS 3	FINISH NO. 3.3.3 OF MIL-STD-171

16. EXCEPT FOR PHOSPHATE COATINGS OR UNLESS OTHERWISE SPECIFIED, DIMENSIONS ON THE DRAWING SHALL APPLY AFTER APPLICATION OF FINAL PROTECTIVE FINISH. IN CASE OF PHOSPHATE COATINGS, DIMENSIONS DO NOT INCLUDE PHOSPHATE COATING THICKNESS.

SUPERSEDED

SYM	DESCRIPTION	DATE	APPROVAL
K	SEE EO-82034	12 FEB 68	
J	REDRAWN AND REVISED	10 APR 59	
H		1 MAY 58	

<b>PHYSICAL PROPERTIES</b> TP TS EL 2 RA BH RH		SMALL ARMS WPN ITEMS SEE ENGRG RECORDS NEXT ASSY USED ON APPLICATION DO NOT DO	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ANGLES MATERIAL HEAT TREATMENT FINAL PROTECTIVE FINISH	ORIGINAL DATE OF DRAWING 25 JUL 51 DRAFTSMAN TRACER ENGINEER SUBMITTED APPROVED BY ORDER OF THE CHIEF OF ORDNANCE H. P. G.	GENERAL DATA GOVERNING MATERIAL, HEAT TREATMENT, AND PROTECTIVE FINISH SCALE UNIT WT	SPRINGFIELD ARMOY ORDNANCE CORPS DEPT OF THE ARMY SPRINGFIELD 1, MASS JWG SIZE B SHEET 3 OF 4 BACKFILE
--	--	---	--	--	---	--

NOTICE: THIS GOVERNMENT DRAWING, SPECIFICATION, OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A GOVERNMENT-RELATED GOVERNMENT PROCUREMENT OPERATION. THE UNITED STATES GOVERNMENT THEREBY INCURS NO RESPONSIBILITY FOR ANY DELAYATION, INACCURACY, OR THE FACT THAT THE GOVERNMENT MAY HAVE FORMULATED, FURNISHED, OR IN ANY WAY SUPPLIED THE SAID DRAWING, SPECIFICATION, OR OTHER DATA. IT IS NOT TO BE REPRODUCED BY APPLICATION OR OTHERWISE IN ANY MANNER LICENSED THE HOLDER OR ANY OTHER PERSON OR CORPORATION, OR CONVEYED ANY RIGHTS OR PERMISSION TO MANUFACTURE, USE, OR SELL ANY INVENTED INVENTION THAT MAY IN ANY WAY BE RELATED THERETO.

B7266102

10. TO COVER BRIGHT SURFACES ON STEEL COMPONENTS WHICH ARE EXPOSED DURING ASSEMBLY OPERATIONS ON AREAS SUCH AS SURFACES OF RIVETS, PINS, SCREW HEADS, STAKING MARKS AND THE LIKE, TOUCH-UP MATERIALS CONFORMING TO THE FOLLOWING REQUIREMENTS MAY BE APPLIED IN LIEU OF REFINISHING WITH SPECIFIED FINAL PROTECTIVE FINISH:
- SHALL BE COLC'ED TO APPROXIMATELY MATCH THE ORIGINAL PRESCRIBED FINISH.
  - SHALL DRY DUST FREE IN 15 MINUTES MAX. AS DETERMINED BY TEST METHOD 4061, FED TEST METHOD STD NO. 141.
  - SHALL BE UNAFFECTED BY CONTACT WITH PRESERVATIVES SPECIFIED FOR USE ON THE COMPONENT TO BE TOUCHED-UP, AS DETERMINED BY TEST METHOD 6011, FED TEST METHOD STD NO. 141.

THE FOLLOWING MATERIALS HAVE BEEN USED SATISFACTORILY:

- STANLEY CHEMICAL COMPANY  
EAST BERLIN, CONN.  
DARK GREY VINYL PRIMER,  
NO. 40X72 (FOR APPLICATION,  
THIN ONE TO ONE WITH STANLEY  
THINNER 79R-192)
- C. W. HAYNES LABORATORY  
61 CHANDLER ST., SPFLD., MASS.  
GREY, AIR-DRYING SYNTHETIC  
LACQUER NO. A6551 (NO THINNER REQUIRED)

SURFACES TO BE TOUCHED UP SHALL BE FREE OF OIL, GREASE, DIRT, SCALE, RUST AND OTHER FOREIGN MATTER.

TOUCH-UP PAINT SHALL NOT BE USED AS A MEANS OF CONCEALING POOR WORKMANSHIP.

11. WHERE NO PROTECTIVE FINISH IS SPECIFIED, NATURAL FINISH OBTAINED FROM HEAT TREATMENT IS PERMISSIBLE.

- UNLESS OTHERWISE SPECIFIED, SURFACES REQUIRING 32 AND FINER ROUGHNESS HEIGHT RATING MAY BE PROCESSED AFTER APPLICATION OF FINAL PROTECTIVE FINISH. BRIGHT AREAS RESULTING FROM SUCH PROCESSING ARE PERMISSIBLE.
- WHEN COMPONENTS ARE BRAZED, WELDED, OR COMBINED BY ANY MEANS INTO A PERMANENT ASSEMBLY, OR IF A PERMANENT ASSEMBLY IS HEAT TREATED AND/OR PROTECTIVE FINISHED, THE COMPONENTS OF THE ASSEMBLY AFTER ANY SUCH OPERATION SHALL BE IN ACCORDANCE WITH DIMENSIONS SPECIFIED ON THE RESPECTIVE COMPONENT AND/OR PRIOR ASSEMBLY DRAWINGS AND APPLICABLE SPECIFICATIONS, UNLESS OTHERWISE SPECIFIED.
- BRAZING MATERIAL SHALL BE CONTROLLED TO PREVENT SPREADING OVER ADJACENT SURFACES. A FINE LINE OF BRAZING MATERIAL SHALL BE VISIBLE AT THE JOINTS AFTER PROTECTIVE FINISH, UNLESS OTHERWISE SPECIFIED.

SUPERSEDED

SYN	DESCRIPTION	DATE	APPROVAL
K	SEE EO-82034	12FEB58	
J	REDRAWN AND REVISED	10APR58	
H		1MAY58	
REVISIONS			

PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 25 JUL 51	GENERAL DATA GOVERNING MATERIAL, HEAT TREATMENT, AND PROTECTIVE FINISH	SPRINGFIELD ARMORY ORDNANCE CORPS DEPT OF THE ARMY SPRINGFIELD 1, MASS
YP		TOLERANCES ON DECIMALS	ANGLES FRACTIONS	DRAFTSMAN		
TS		MATERIAL	HEAT TREATMENT	TRACER		
EL 2		HEAT TREATMENT	HEAT TREATMENT	ENGINEER		
RA	SEE ENGRG RECORDS	APPLICATION	DO NOT APPLY PART NO.	DO	APPROVED BY ORDER OF THE CHIEF OF ARMORY	DWG SIZE B
BH	NEXT ASST USED ON	DO	AS SPECIFIED	DO	APPROVED BY ORDER OF THE CHIEF OF ARMORY	SHEET 2 OF 4
QH		DO	AS SPECIFIED	DO	APPROVED BY ORDER OF THE CHIEF OF ARMORY	BACKFILE

1176-3

8 7266102

1. SPECIFICATION MIL-W-13855 SHALL APPLY.

2. HEAT TREATMENT SHALL BE PERFORMED CORRECTLY TO PRODUCE THE PHYSICAL PROPERTIES AND THE HARDNESS REQUIRED. TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT REQUIRED ON THE COMPONENT DRAWING. HEAT TREATING METHODS, CONTROL, AND EQUIPMENT SHALL BE SUCH THAT NO INJURIOUS DECARBURIZATION OR SCALING IS PRODUCED ON THE FINISHED COMPONENTS.

HEAT TREATMENTS INDICATED ON DRAWINGS ARE FOR GUIDANCE, EXCEPT FOR ABOVE PROVISIONS WHICH ARE MANDATORY.

ALTERNATIVE MATERIALS: ADJUST THE HEAT TREATMENT IF NECESSARY TO OBTAIN THE SPECIFIED PHYSICAL PROPERTIES.

3. WHEN NORMALIZING IS SPECIFIED, DETAILS OF THIS HEAT TREATMENT MAY BE CHOSEN BY THE MANUFACTURER TO SUIT HIS PARTICULAR FACILITIES. SUCH HEAT TREATMENT SHALL REFINE ANY COARSE-GRAINED, HOT-WORKED STRUCTURE.

4. EXCEPT AS OTHERWISE SPECIFIED ON DRAWINGS, HARDNESS REQUIREMENTS SHALL APPLY THROUGHOUT THE ENTIRE COMPONENT OR ASSEMBLY. WHEN SPECIFIC LOCATIONS FOR HARDNESS TESTS ARE INDICATED, TESTS MAY BE MADE ON ADDITIONAL AREAS TO DETERMINE UNIFORMITY OF HEAT TREATMENT. THE RESULTS OF THESE TESTS, WHEN NOT WITHIN SPECIFIED LIMITS OF THE DRAWING, SHALL BE REFERRED TO THE CONTRACTING OFFICER FOR DECISION ON ADEQUACY OF HEAT TREATMENT.

5. HARDNESS REQUIREMENTS SHALL BE CHECKED BY USING THE HARDNESS SCALE SPECIFIED ON THE PERTINENT COMPONENT OR ASSEMBLY DRAWING. IN THE EVENT IT IS CONSIDERED DESIRABLE TO CHECK UNIFORMITY OF HEAT TREATMENT BY CONVERSION FROM A SCALE OTHER THAN THAT SPECIFIED, APPROVAL FOR USE OF SUCH SCALE MUST BE OBTAINED FROM THE CONTRACTING OFFICER.

6. CASE DEPTHS REQUIRED ARE MEASURED ON FRACTURES OF OIL QUENCHED SAMPLES. (TEST SAMPLES MAY BE SCRAP COMPONENTS OR TEST PIECES OF EQUIVALENT ANALYSIS AND CROSS SECTION WHICH ARE HEAT TREATED WITH THE LOT.)

7. WHERE FILE HARD IS REQUIRED, THE SURFACES OF THE COMPONENTS SHALL NOT BE CUT APPRECIABLY BY A 6 INCH #0 PILLAR TEST FILE, OR EQUAL, USED BY AN OPERATOR EXPERIENCED IN FILE TESTING: A HARD WEAR-RESISTANT SURFACE IS REQUIRED.

8. WHENEVER THE RECOMMENDED HEAT TREATMENT CALLS FOR A CARBURIZING TREATMENT, THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESS WILL NOT BE PERMITTED WITHOUT THE PRIOR APPROVAL OF THE CONTRACTING OFFICER.

9. EXCEPT WHERE OTHERWISE NOTED, HARDNESS LIMITS APPLY TO TESTS MADE ON SUFFICIENTLY SMOOTH, FLAT, AND PROPERLY SUPPORTED SURFACES. HARDNESS TESTS MADE UNDER OTHER CONDITIONS MAY BE USED ONLY WHEN NECESSARY IF RESULTS ARE COMPENSATED FOR THE ERROR INTRODUCED BY SUCH CONDITIONS.

SUPERSEDED

REV	DESCRIPTION	DATE	APPROVAL
K	SEE EO-82034	12 FEB 68	<i>R. H. H. H.</i>
J	SEE E.O. SA 25064	10 APR 59	<i>R. H. H. H.</i>
H	REDRAWN AND REVISED	1 MAY 58	<i>R. H. H. H.</i>
G		7 DEC 56	

PHYSICAL PROPERTIES		SMALL ARMS WPN ITEMS		TOLERANCES ON DECIMALS		ORIGINAL DATE OF DRAWING 25 JUL 51		GENERAL DATA		SPRINGFIELD ARMOY ORDNANCE CORP	
TP		SEE ENGINEERING RECORDS		ANGLES	FRACTIONS	DRAFTSMAN DSK	CHECKER <i>R. H. H. H.</i>	GOVERNING MATERIAL, HEAT TREATMENT, AND PROTECTIVE FINISH		DEPT OF THE ARMY SPRINGFIELD 1, MASS	
EL				MATERIAL		TRACER DSK	CHECKER <i>R. H. H. H.</i>			DWC 7266102	
SA				HEAT TREATMENT		ENGINEER <i>R. H. H. H.</i>	ENGINEER <i>R. H. H. H.</i>			B 1 4	
BN		APPLICATION		FINAL PROTECTIVE FINISH		SUBMITTED	APPROVED <i>R. H. H. H.</i>	SCALE		UNIT WT	
BN		DO NOT APPLY PART NO.				CHIEF OF OFFICE				BACKFILE	
BN		DO AS SPECIFIED									

NOTICE: WHEN GOVERNMENT DRAWINGS, SPECIFICATIONS, OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFENSE-RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT TAKES NO RESPONSIBILITY FOR ANY OBLIGATION WHATSOEVER, AND THE FACT THAT THE GOVERNMENT MAY HAVE FORMERLY PROVIDED OR IN ANY WAY SUPPLIED THE SAID DRAWING, SPECIFICATION, OR OTHER DATA IS NOT TO BE DEEMED BY IMPLICATION OR OTHERWISE AS IN ANY MANNER LICENSE, THE HOLDING OF ANY OTHER PERSON OR CORPORATION, OR COMPANY, ANY RIGHTS OR PERMISSION TO MANUFACTURE, USE, OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE RELATED THEREIN.

2099278

# 17. FINAL PROTECTIVE FINISHES

UNLESS OTHERWISE SPECIFIED ON THE COMPONENT DRAWING THE FOLLOWING SHALL APPLY TO THE PHOSPHATING AND OXIDIZING PROCESSES:

PHOSPHATE-COATED PARTS SHALL BE RINSED IN A CHROMIC ACID SOLUTION. BLACK OXIDE PARTS SHALL BE RINSED IN EITHER A CHROMIC ACID SOLUTION OR WATER AS PRESCRIBED IN SPEC MIL-C-13924. ON EMERGENCE FROM THE PRESCRIBED RINSE, PARTS SHALL BE THOROUGHLY DRIED BEFORE APPLYING THE SUPPLEMENTARY PRESERVATIVE. UNLESS OTHERWISE AUTHORIZED, DRYING SHALL BE ACCOMPLISHED BY THE USE OF DRYING OVENS, HEATED FORCED AIR CIRCULATION, OR FILTERED COMPRESSED AIR. THE DRYING TEMPERATURE SHALL NOT EXCEED 200°F.

UNLESS OTHERWISE SPECIFIED, THE SUPPLEMENTARY PRESERVATIVE FOR CLASS I COATINGS IN ACCORDANCE WITH SPEC MIL-P-16232 AND BLACK OXIDE COATINGS IN ACCORDANCE WITH SPEC MIL-C-13924 SHALL CONFORM TO SPEC MIL-L-644.

NO CARRY OVER OF RESIDUES FROM THE PHOSPHATING OR OXIDIZING SOLUTIONS TO THE OIL SHALL BE PERMITTED. PERIODIC TESTS OF THE OIL SHALL BE MADE AT LEAST SEMI-MONTHLY TO INSURE THAT THE OIL CONTINUES TO MEET SPECIFICATION REQUIREMENTS FOR CORROSION PROTECTION.

THE SPRINGFIELD IMMERSION TEST IS AUTHORIZED FOR USE IN ACCELERATED CORROSION TESTS, REF PAR 3.5.2 SPEC MIL-P-16232

18. WHERE THE COMPONENT DRAWING SPECIFIES "FS" OR "C" STEELS IN ACCORDANCE WITH FED SPECIFICATION QQ-S-624 OR QQ-S-633 OR THE STEEL NUMBER SPECIFIED ON THE DRAWING IS NOT LISTED IN THE LATEST REVISION OF THE STEEL SPECIFICATION, CHEMICAL COMPOSITION AND HARDENABILITY SHALL BE IN ACCORDANCE WITH THAT SPECIFIED FOR CORRESPONDING NUMBERS WITHOUT PREFIX LETTERS LISTED IN FED STD NO. 66 AND OTHER REQUIREMENTS SHALL BE IN ACCORDANCE WITH THE STEEL SPECIFICATION.

SUPERSEDED

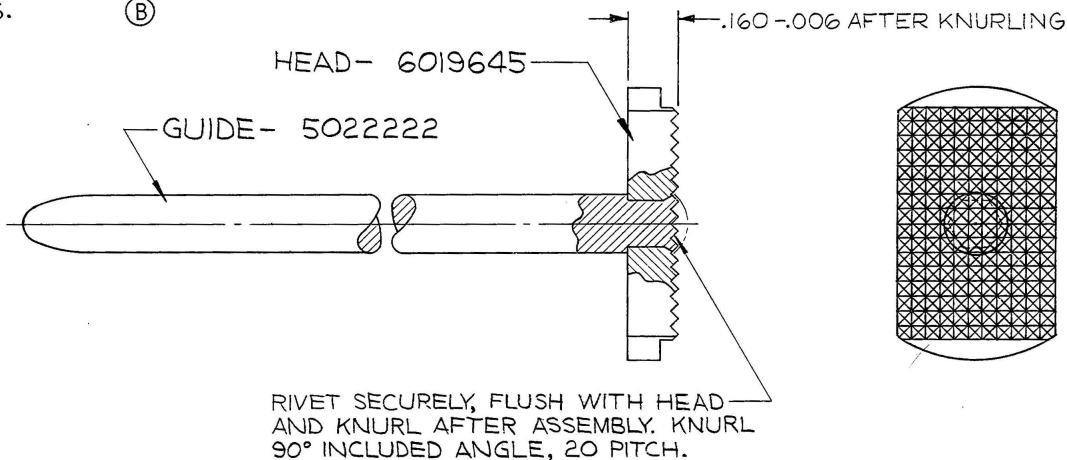
SYM	DESCRIPTION	DATE	APPROVAL
K	SEE EO-82034	12 FEB 68	<i>[Signature]</i>
J	REDRAWN AND REVISED	10 APR 59	<i>[Signature]</i>
H		1 MAY 58	

<b>PHYSICAL PROPERTIES</b> YP TS EL2 RA BH RH		SMALL ARMS WPN ITEMS SEE ENGRG RECORDS NEXT ASSY USED ON APPLICATION DO NOT DO	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ANGLES FRACTIONS MATERIAL HEAT TREATMENT FINAL PROTECTIVE FINISH	ORIGINAL DATE OF DRAWING 25 JUL 51 DRAFTSMAN TRACER ENGINEER SUBMITTED APPROVED BY ORDER OF THE CHIEF OF ORDNANCE H. T. Louchard CORPS	GENERAL DATA GOVERNING MATERIAL, HEAT TREATMENT, AND PROTECTIVE FINISH SCALE UNIT WT	SPRINGFIELD ARMORY ORDNANCE CORPS DEPT OF THE ARMY SPRINGFIELD 1, MASS DWG SIZE B 7266102 SHEET 4 OF 4 BACKFILE
---	--	---	--	--	---	--

# NOTES:

1. HEAT TO 1425° F - 1450° F. QUENCH IN OIL. TEMPER AT 700° F TO ROCKWELL SPECIFIED. HEAT TREAT METHOD IS FOR GUIDANCE ONLY.
2. HEAD SHALL BE TIGHT TO GUIDE AFTER HEAT TREATMENT.
3. STRAIGHTNESS REQUIREMENT: AFTER HEAT TREATMENT GUIDE SHALL DROP OF ITS OWN WEIGHT FOR ITS FULL LENGTH INTO A .202 DIA HOLE 6.50 INCHES LONG.
4. FINISH 5.3.1.2 OF MIL-STD-171.
5. MIL-W-13855 APPLIES.

(B)



REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	REPLACES REV 12 W/ CHANGE		
			SEE EO RIA-14303	8-10-67	J. H. Flier
		B	SEE NOR 75E0002-0002	24JUL75	80/2/2/2/2/2/2

SEE EPL-6019677

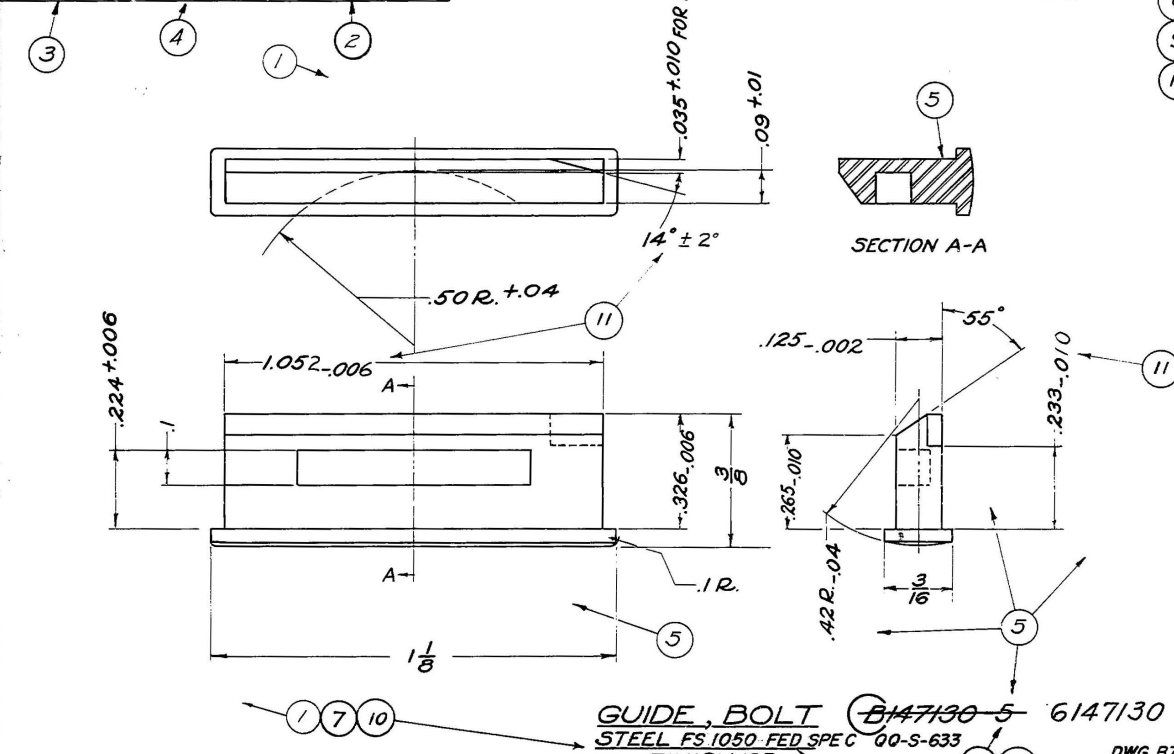
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING MAY 1, 1929		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON	DECIMALS	DRAFTSMAN	CHECKER	GUIDE ASSEMBLY	
TS		ANGLES ±	XXX ±	ELJ	LSC		
EL 2		MATERIAL		TRACER	CHECKER		
RA		HEAT TREATMENT		ENGINEER	ENGINEER		
BH				SA		DWG SIZE CODE, IDENT NO.	
RH	C45-50	M1918A2 F7265703 .30 BAR	SEE NOTE 1	SUBMITTED		C 19204 6019677	
APPLICATION		FINAL PROTECTIVE FINISH	SEE NOTE 4	APPROVED		SCALE 4/1 UNIT WT SHEET OF 1	
				Z. CRANA			
				S. P. SPALDING			

NOTED: THIS DRAWING SHALL NOT BE USED OR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

HEAT TREATMENT & PROT. FINISH  
HEAT TO 1475°F-1500°F  
QUENCH IN OIL  
TEMPER AT 700°F  
PROT. FIN. TYPE II CLASS A USA 57-0-2

DO NOT INSCRIBE PART NO.

PHYSICAL PROPERTIES		JUNE 1, 1936.	
		REVISIONS	
Y.P.		13	4-15-38
T.S.		23	6-1-39
EL-2		32	2-27-40
RED		41	6-25-40
HT. T.		53	9-21-42
BR.		61	4-15-44
		71	1-21-49
SCL.		83	7-28-49
		91	7-21-50
C.C.			DELETED 11-15-50
ROCK. D 60-66		104	3-4-52
		112	8-18-52
		121	9 JUNE 55



TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.  
SUPERSEDES OLD TRACING A2221 UNDER REVISION DATE OF JUNE 1, 1936.

GUIDE BOLT B147130-5 6147130  
STEEL FS 1050-FED SPEC 00-S-633  
FINISH 125

DWG B7266102 APPLIES

SCALE 4/1

B6147130  
B147130

DRG. PERTAINS TO  
51 13 30 B.A.R. M18

FT265703 30 B.A.R. M1918A2

SYMBOL  
JAG 295

DFTSMAN TRACER L'D.G. DFTSMAN  
EL. J. G. H. B. 0.9. C.

CHECKER L. S. G. CHIEF DFTSMAN  
SUBMITTED

APPROVED BY ORDER OF THE  
CHIEF OF ORDNANCE  
S. J. S. L. T. COL. ORD. DEPT. U. S. A.

ORDNANCE DEPT. U.S.A.

SUPERSEDES B147130

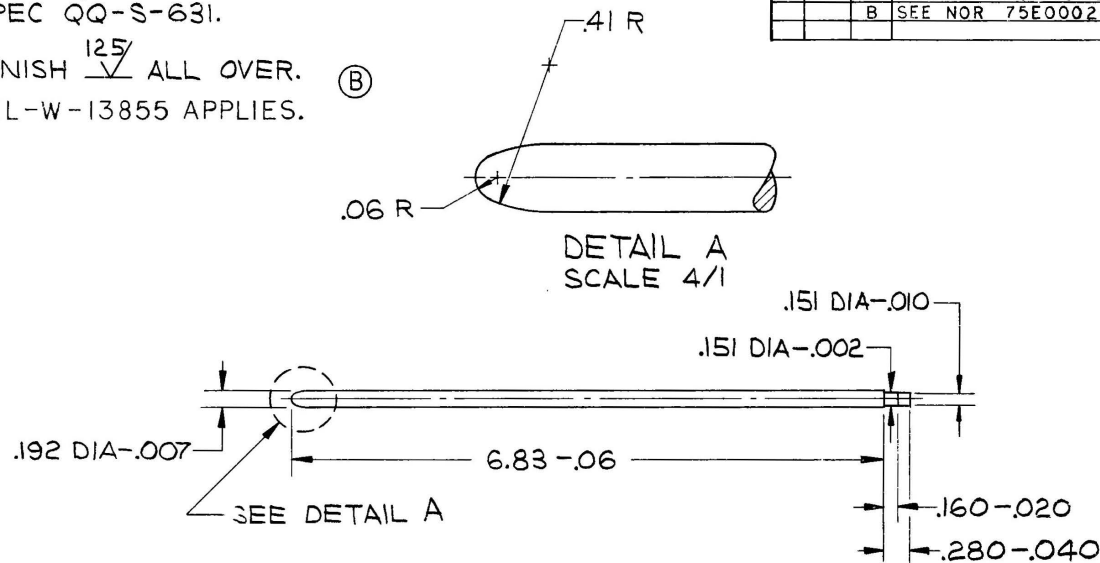
B6147130



1. STEEL, CMPSN 1095  
SPEC QQ-S-631.

2. FINISH  $\frac{125}{\sqrt{\quad}}$  ALL OVER.  
3. MIL-W-13855 APPLIES.

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	REPLACES REV 5 W/CHANGE SEE EO RIA-14303	8-10-67	J.H. F. Lee
		B	SEE NOR 75E0002-0000	24 JUL 75	W. H. H. Smith



A	MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING MAY 1, 1929		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201			
	YP				TOLERANCES ON DECIMALS XX ± .01		DRAFTSMAN ELJ CHECKER LSC		GUIDE			
	TS				ANGLES ± XXX ±		TRACER <i>W. J. Smith</i> CHECKER					
	EL 2				MATERIAL		ENGINEER JJC ENGINEER EMW					
	RA		M1918A2		SEE NOTE 1		SUBMITTED		DWG. SIZE CODE IDENT NO. B 19204 5022222			
	BH	C6019677	.30 BAR		HEAT TREATMENT		Z. CRANA					
	RH	APPLICATION		FINAL PROTECTIVE FINISH		APPROVED S. P. SPALDING						
		NEXT ASSY. USED ON						SCALE 1/1 UNIT WT SHEET 1 OF 1				

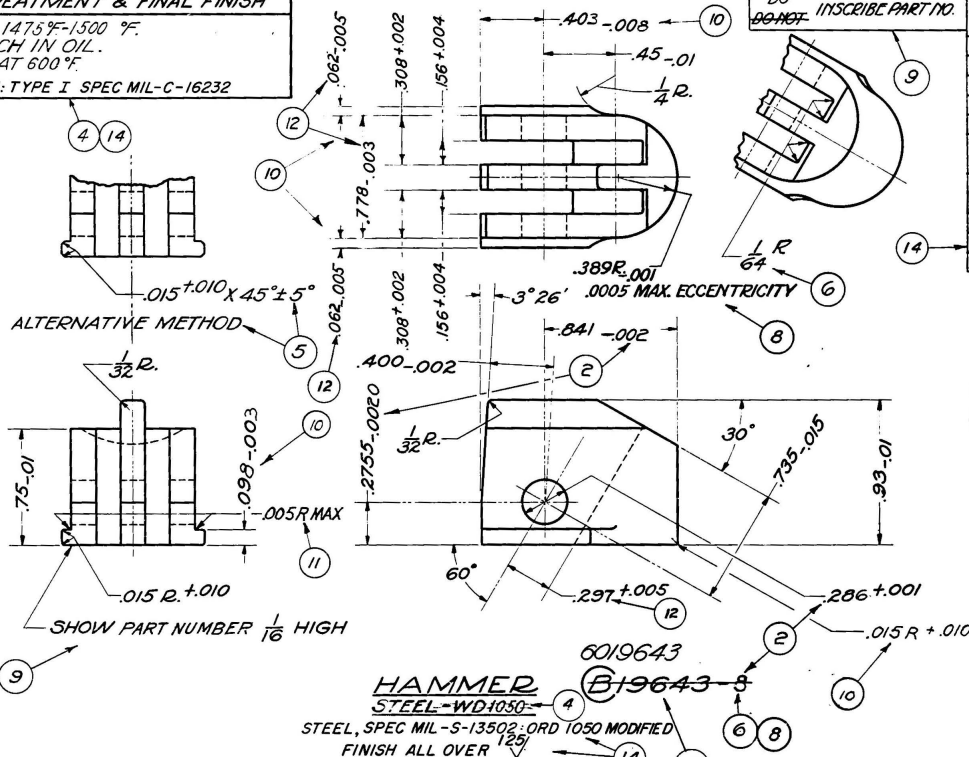
SWERI FORM 40 B, 1 MAR 67

# HEAT TREATMENT & FINAL FINISH

HEAT TO 1475°F-1500 °F.  
QUENCH IN OIL.  
TEMPER AT 600 °F.

PROT. FINISH: TYPE I SPEC MIL-C-16232

NOTICE: THIS DRAWING SHALL NOT BE USED OR  
REPRODUCED EITHER WHOLLY OR IN PART EXCEPT  
WHEN AUTHORIZED IN CONNECTION WITH  
UNITED STATES GOVERNMENT PROCUREMENT.



**HAMMER**  
**STEEL-WD1050**

STEEL, SPEC MIL-S-13502: ORD 1050 MODIFIED  
FINISH ALL OVER

TOLERANCE  $\pm .01$  ALLOWED ON ALL DIMEN-  
SIONS UNLESS OTHERWISE SPECIFIED.

SUPERSEDES OLD TRACING B19643 UNDER REVISION DATE OF JUNE 1, 1936.

DWG B7266102 APPLIES

SCALE  $\frac{2}{1}$

## PHYSICAL PROPERTIES

Y.P.	
T.S.	
EL-2	
RED.	
HT.T.	
BR.	
SCL.	
C.C.	
ROCK D60-66	

MAY 1, 1929.

## REVISIONS

1	6-1-36	13	9 JUNE 55
2	12-1-37	14	19 AUG 55
3	4-15-38		
4	6-1-39		
5	11-30-42		
6	12-1-43		
7	4-15-44		
8	10-28-44		
9	11-15-45		
10	6-17-58		
11	4-7-53		
12	11-2-53		

## DRG. PERTAINS TO

51-13	30-B.A.R. M18
F7265705	30-B.A.R. M1918 A2

## SYMBOL

WCH 13

DFTSMAN	TRACER	L.D.G. DFTSMAN
EL.J.	W.C.	W.C.
CHECKER	CHEF DFTSMAN	
W.C.	W.C.	

SUBMITTED  
CPT. ORD. DEPT. U. S. A.

APPROVED BY ORDER OF THE  
CHIEF OF ORDNANCE:  
J. I. Spence  
LT. COL. ORD. DEPT. U. S. A.

ORDNANCE DEPT. U. S. A.

SUPERSEDES B19643

B6019643

11

5. MIL-W-13855 APPLIES.

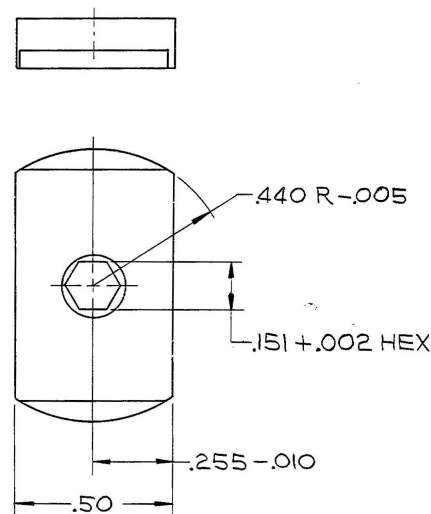
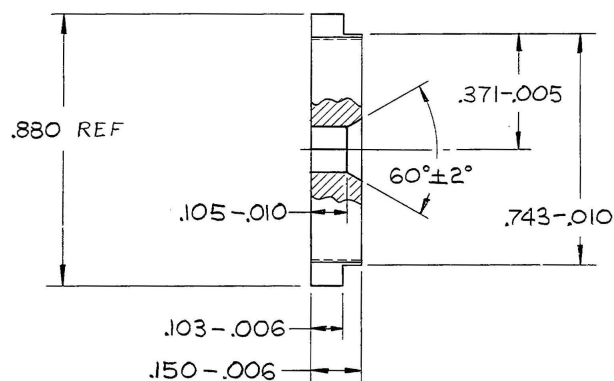
EDITION OF 29 JUL 70 MAY BE USED.



NOTES:

1. STEEL, CMPSN 1095, SPEC QQ-S-631  
OR  
STEEL, CMPSN 1095, SPEC QQ-S-700.
2. FINISH  $\sqrt[125]{}$  ALL OVER.
3. MIL-W-13855 APPLIES. (B)

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	REPLACES REV 10 W/CHG	
			SEE EO RIA-14303	8-10-67
		B	SEE NOR 75E0002-0001	24 JUL 75

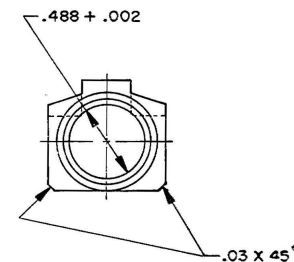
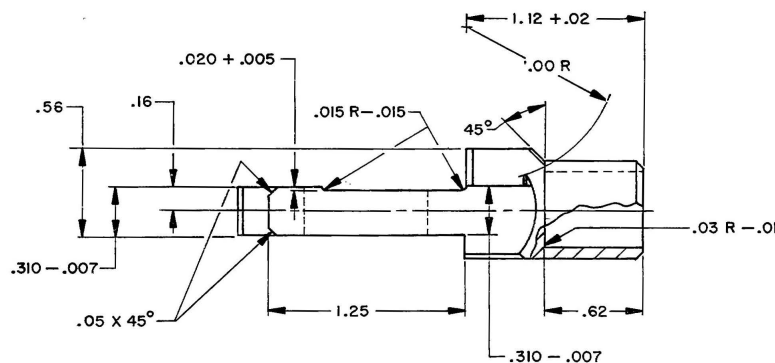
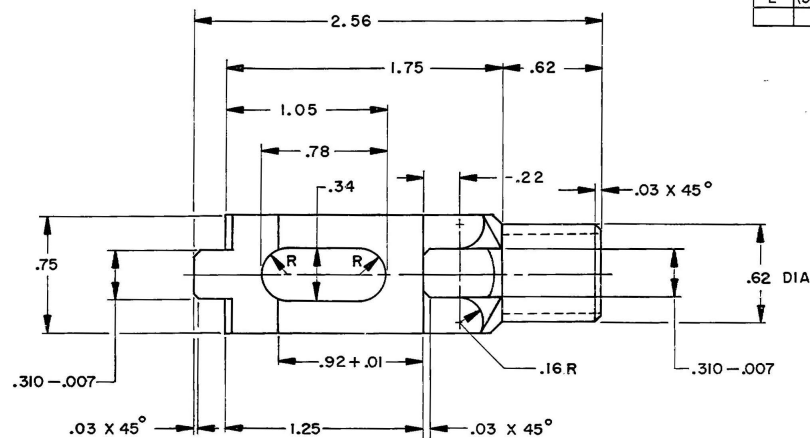


MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING MAY 1, 1929		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON	DECIMALS	DRAFTSMAN	CHECKER	HEAD	
TS		ANGLES ±	.XX ± .01	ELJ	LSC		
EL 2		MATERIAL	XXX ±	TRACER	CHECKER		
RA		SEE NOTE 1		ENGINEER	ENGINEER		
BH		HEAT TREATMENT		JJC	CMW	SUBMITTED	
RH		FINAL PROTECTIVE FINISH		Z. CRANA		DWG SIZE	
NEXT ASSY.		USED ON		APPROVED		C 19204	
APPLICATION				S.P. SPALDING		6019645	
						SCALE 4/1 UNIT WT SHEET 1 OF 1	

NOTES:

1. FINISH ALL OVER  $\sqrt{125}$ .
2. CORNERS AND EDGES SHALL BE BROKEN .005 + .010 UNLESS OTHERWISE SPECIFIED AND SHALL BE FREE OF BURRS.
- 3A. FOR WROUGHT MATERIAL:  
STEEL, COMP 8620, SPEC QQ-S-624.
- B. FOR PRECISION CASTING:  
STEEL, COMP IC 1020, SPEC MIL-S-22141.  
TENSILE TEST SHALL NOT APPLY.
4. CLASSIFICATION AND INSPECTION OF INVESTMENT CASTING SHALL BE IN ACCORDANCE WITH CLASS IB, GRADE B, SPEC MIL-C-6021.
5. MIL-W-13855 APPLIES. (E)

REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED
D	REDRAWN & REVISED W/CHANGE SEE EO RIA-14493	16 NOV 67	<i>R. L. Homan</i>
E	(3)SEE ERR HQR 20772	22 SEP 72	<i>PL. L. L. L.</i>



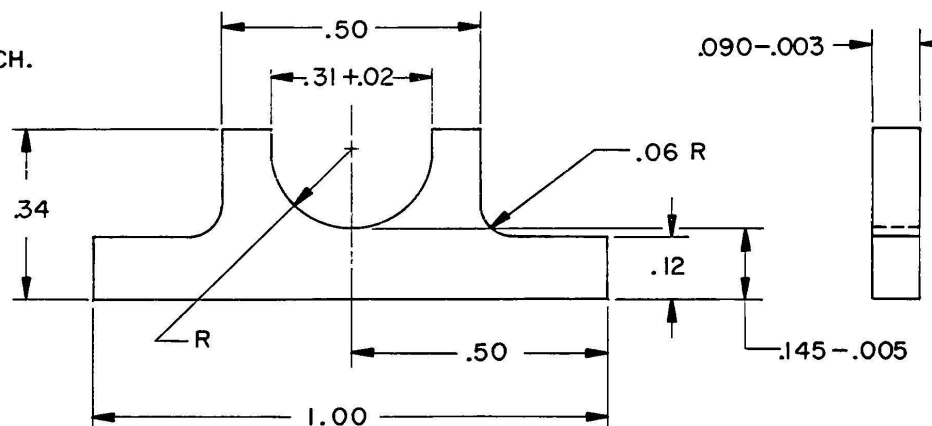
PART NO. 6147338 (E)

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 JUN 39		DEPT OF THE ARMY	
YP		C7312235	.30 BAR	TOLERANCES ON DECIMALS $\pm .02$	DRAFTSMAN G. V. S.	CHECKER T. J. W.	U.S. ARMY WEAPONS COMMAND, ROCK ISLAND, ILL. 61201
TS			M1918A2:	FRACTIONS $\pm$	TRACER C. R. H. H. H.	CHECKER C. R. H. H. H.	
EL 2			.30 BMG	ANGLES $\pm 1^\circ$	ENGINEER D. HORN	ENGINEER L. J. LONCRINI	
RA			M1919A6	MATERIAL SEE NOTE 3	SUBMITTER <i>R. J. Henry</i>		JOINT, BIPOD LEG
BH		SEE ENGINEERING RECORDS		HEAT TREATMENT	APPROVED <i>W. J. L. L.</i>		
RH		NEXT ASSY USED ON APPLICATION		AT ASSEMBLY	DWG SIZE C		CODE IDENT NO. 19204
		APPLY PART NO.		FINAL PROTECTIVE FINISH	UNIT WT .16		6147338
				APPLIED AFTER ASSEMBLY	SHEET 1 OF 1		

# NOTES: 125/

1. FINISH  $\checkmark$  ALL OVER.
2. EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL:  
STEEL, COMP 1020 THRU 1022,  
SPEC QQ-S-698.
4. HEAT TREATMENT:  
HEAT AT 1550° TO 1600° F TO CASE  
DEPTH OF .005 TO .01 DEEP. OIL QUENCH.  
TEMPER AT 350° F MINIMUM FOR  
30 MINUTES TO HARDNESS SPECIFIED.  
HEAT TREATMENT METHOD IS FOR  
GUIDANCE ONLY EXCEPT TEMPERING  
TIME SHALL NOT BE REDUCED  
BELOW THAT SPECIFIED.
5. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2 OF  
MIL-STD-171.
6. FILEHARD TEST IN ACCORDANCE  
WITH SA-STD-104.

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	REDRAWN WITH CHANGE SEE EO HRD 82243	25 NOV68	<i>H. R. Ash</i>

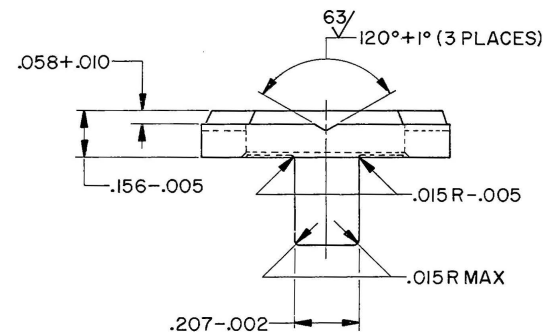
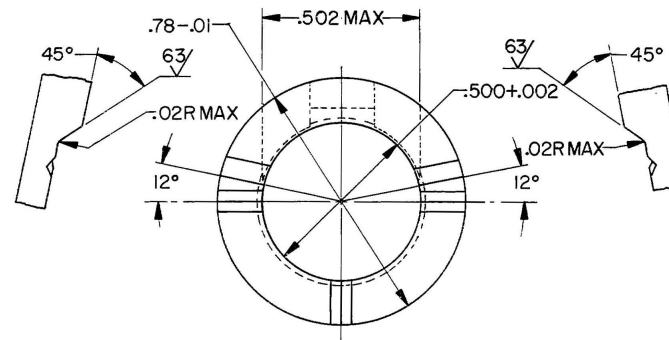
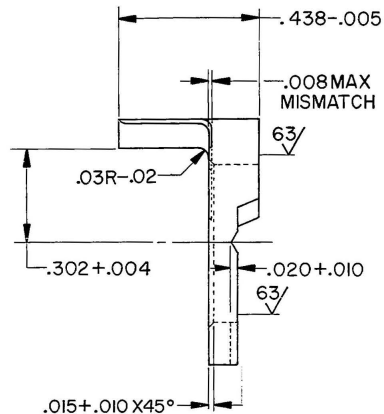


PART NO. 7312238

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 JUN 1944		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON DECIMALS .XX ± .01		DRAFTSMAN <i>C. Q. Haugler</i>	CHECKER <i>S. Frutiger</i>	KEY	
TS		ANGLES ± .XXX ±		TRACER <i>C. Q. Haugler</i>	CHECKER <i>S. Frutiger</i>		
EL 2		MATERIAL SEE NOTE 3		ENGINEER <i>H. R. Ash</i>	ENGINEER	DWG SIZE B	CODE IDENT NO. 19204
RA	D7312239	HEAT TREATMENT SEE NOTE 4		SUBMITTED <i>W. Johnson</i>		7312238	
BH	C 7148442	FINAL PROTECTIVE FINISH SEE NOTE 5		APPROVED <i>W. Johnson</i>		SCALE 5 / 1	UNIT WT
RH	FILEHARD SEE NOTE 6	APPLICATION				SHEET 1	OF 1

# NOTES:

1. FINISH  $\sqrt{125}$  ALL OVER UNLESS OTHERWISE SPECIFIED.
2. ALL EDGES SHALL BE BROKEN  $.005 \pm .010$  UNLESS OTHERWISE SPECIFIED.
3. MATERIAL:  
STEEL, COMP 1045 THRU 1050,  
SPEC ASTM A108
4. HEAT TREATMENT:  
HEAT AT 1525°-1550°F OIL QUENCH.  
TEMPER 30 MINUTES TO HARDNESS  
SPECIFIED. HEAT TREATMENT  
METHOD IS FOR GUIDANCE ONLY,  
EXCEPT TEMPERING TIME SHALL  
NOT BE REDUCED BELOW THAT  
SPECIFIED.
5. NO DECARBURIZATION NOR SCALE  
IS TO BE ALLOWED AS A RESULT  
OF HEAT TREATMENT.
6. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OF MIL-STD-171.
7. MIL-W-13855 APPLIES.



REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
1		C	REDRAWN WITH CHANGE	14 JUL 69
			SEE EO HRD 92117	26 FEB 75
		D	SEE ERR HQR 50616	

PART NO. 7267815

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 27 MAY 55		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON DECIMALS		DRAFTSMAN	CHECKER	KEY, BODY	
TS		ANGLES $\pm 1^\circ$		M.C. Munch	C.W. Tindall		
EL 2		MATERIAL		TRACER	CHECKER		
RA		SEE NOTE 3		M.C. Munch	C.W. Tindall		
BH		HEAT TREATMENT		ENGINEER	ENGINEER	7267815	
RH	C35-40	SEE NOTE 4 & 5		THEODORE B. FORENGER JR.			
		FINAL PROTECTIVE FINISH		APPROVED		DWG SIZE	CODE IDENT NO.
		SEE NOTE 6				C	19204
		APPLICATION				SCALE 4/1	UNIT WT
							SHEET OF 1





NOTICE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

HEAT TREATMENT & FINAL FINISH  
 PROT FINISH AT ASSEMBLY (TYPE II CLASS  
 A OR B USA SPEC 57-0-2 SPARES ONLY)

~~DO NOT~~ INSCRIBE PART NO.

PHYSICAL  
 PROPERTIES

~~A22223~~  
 MAY 1, 1929.

REVISIONS

1	6-1-36	6 <sup>2</sup>	10-28-42
2 <sup>1</sup>	4-15-38	7 <sup>3</sup>	10-12-43
3 <sup>2</sup>	6-1-39	8 <sup>1</sup>	4-15-44
4 <sup>1</sup>	2-27-40	9 <sup>2</sup>	CONVERSION 1-28-49 DELETED 11-15-50
5	4-25-42	10 <sup>1</sup>	12-18-50

DRG. PERTAINS TO

~~D-8769 BARREL, ASSEMBLY~~  
~~51-13-30 B.A.R. M-18~~  
~~D6508769~~

51-102 30 BAR-M1918 A2

SYMBOL

GAK 283

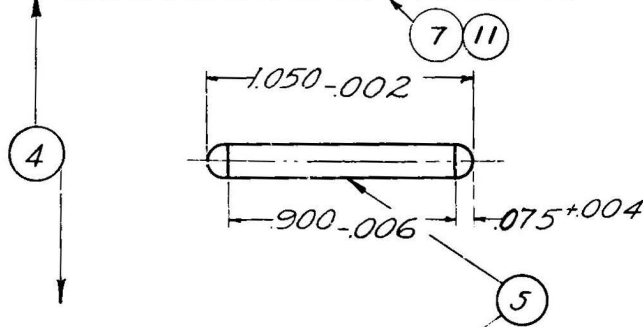
D'FTSMAN E. L. J.	TRACER P. R. A.	L'D'G. D'FTSMAN A. J. C.
CHECKER L. S. E.	CHEF D'FTSMAN C. M. A.	CHIEF D'FTSMAN M. R. O.

SUBMITTED  
*[Signature]*  
 CAPT. ORD. DEPT. U.S.A.

APPROVED BY ORDER OF THE  
 CHIEF OF ORDNANCE:-  
*[Signature]*  
 LT. COL. ORD. DEPT. U.S.A.

ORDNANCE DEPT. U.S.A.

A5022223



KEY, FRONT SIGHT ~~A 22223~~  
 STEEL, FED SPEC QQ-S-633, FS1020  
 FINISH 125/

5022223

A5022223

~~A 22223~~

TOLERANCE  $\pm .01$  ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.  
 SUPERSEDES OLD TRACING A22223  
 UNDER REVISION DATE OF JUNE 1, 1936

DWG B7266102 APPLIES

SCALE 2

SUPERSEDES A22223

5		4		3		2		1																																																						
<p><b>NOTES:</b></p> <p>1. STEEL, COMP 1095, SPEC QQ-S-631 OR STEEL, TOOL, CLASS W1-09, SPEC QQ-T-580.</p> <p>2. FINISH ALLOVER <math>\sqrt{125}</math></p> <p>3. HEAT AT 1450° TO 1475° F. OIL QUENCH. TEMPER 1 HOUR AT 850° F TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE ONLY EXCEPT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.</p>						<p><b>REVISIONS</b></p> <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th>MF</th> <th>ZONE</th> <th>LTR</th> <th>DESCRIPTION</th> <th>DATE</th> <th>APPROVED</th> </tr> </thead> <tbody> <tr> <td></td> <td></td> <td>A</td> <td>REPLACES REV 8 W/CHANGE</td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td>SEE EO R1A - 14433</td> <td>4 OCT 67</td> <td><i>R. Henry</i></td> </tr> </tbody> </table>				MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED			A	REPLACES REV 8 W/CHANGE						SEE EO R1A - 14433	4 OCT 67	<i>R. Henry</i>																																			
						MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED																																																			
								A	REPLACES REV 8 W/CHANGE																																																					
									SEE EO R1A - 14433	4 OCT 67	<i>R. Henry</i>																																																			
<p><b>MECHANICAL PROPERTIES</b></p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td>YP</td> <td></td> </tr> <tr> <td>TS</td> <td></td> </tr> <tr> <td>EL 2</td> <td></td> </tr> <tr> <td>RA</td> <td>D5564074 BAR, CAL 30</td> </tr> <tr> <td>BH</td> <td>MI918A2</td> </tr> <tr> <td>RH</td> <td>C33-38</td> </tr> </table>		YP		TS		EL 2		RA	D5564074 BAR, CAL 30	BH	MI918A2	RH	C33-38	<p>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td>TOLERANCES ON DECIMALS</td> <td></td> </tr> <tr> <td>ANGLES ± 1°</td> <td></td> </tr> <tr> <td>MATERIAL</td> <td>SEE NOTE 1</td> </tr> <tr> <td>HEAT TREATMENT</td> <td>SEE NOTE 3</td> </tr> <tr> <td>FINAL PROTECTIVE FINISH</td> <td></td> </tr> </table>		TOLERANCES ON DECIMALS		ANGLES ± 1°		MATERIAL	SEE NOTE 1	HEAT TREATMENT	SEE NOTE 3	FINAL PROTECTIVE FINISH		<p>ORIGINAL DATE OF DRAWING 1 MAY 1929</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td>DRAFTSMAN</td> <td>EL J</td> <td>CHECKER</td> <td>L S C</td> </tr> <tr> <td>ENGINEER</td> <td>MEB</td> <td>ENGINEER</td> <td>CMW</td> </tr> <tr> <td colspan="4">SUBMITTED</td> </tr> <tr> <td colspan="4">P. G. CROW</td> </tr> <tr> <td colspan="4">APPROVED</td> </tr> <tr> <td colspan="4">S. P. SPALDING</td> </tr> </table>		DRAFTSMAN	EL J	CHECKER	L S C	ENGINEER	MEB	ENGINEER	CMW	SUBMITTED				P. G. CROW				APPROVED				S. P. SPALDING				<p>DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201</p> <p style="text-align: center; font-weight: bold;">KEY</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td>DWG SIZE</td> <td>CODE IDENT NO.</td> <td></td> </tr> <tr> <td>B</td> <td>19204</td> <td>5022224</td> </tr> <tr> <td>SCALE 10/1</td> <td>UNIT WT</td> <td>SHEET 1 OF 1</td> </tr> </table>		DWG SIZE	CODE IDENT NO.		B	19204	5022224	SCALE 10/1	UNIT WT	SHEET 1 OF 1
YP																																																														
TS																																																														
EL 2																																																														
RA	D5564074 BAR, CAL 30																																																													
BH	MI918A2																																																													
RH	C33-38																																																													
TOLERANCES ON DECIMALS																																																														
ANGLES ± 1°																																																														
MATERIAL	SEE NOTE 1																																																													
HEAT TREATMENT	SEE NOTE 3																																																													
FINAL PROTECTIVE FINISH																																																														
DRAFTSMAN	EL J	CHECKER	L S C																																																											
ENGINEER	MEB	ENGINEER	CMW																																																											
SUBMITTED																																																														
P. G. CROW																																																														
APPROVED																																																														
S. P. SPALDING																																																														
DWG SIZE	CODE IDENT NO.																																																													
B	19204	5022224																																																												
SCALE 10/1	UNIT WT	SHEET 1 OF 1																																																												

4

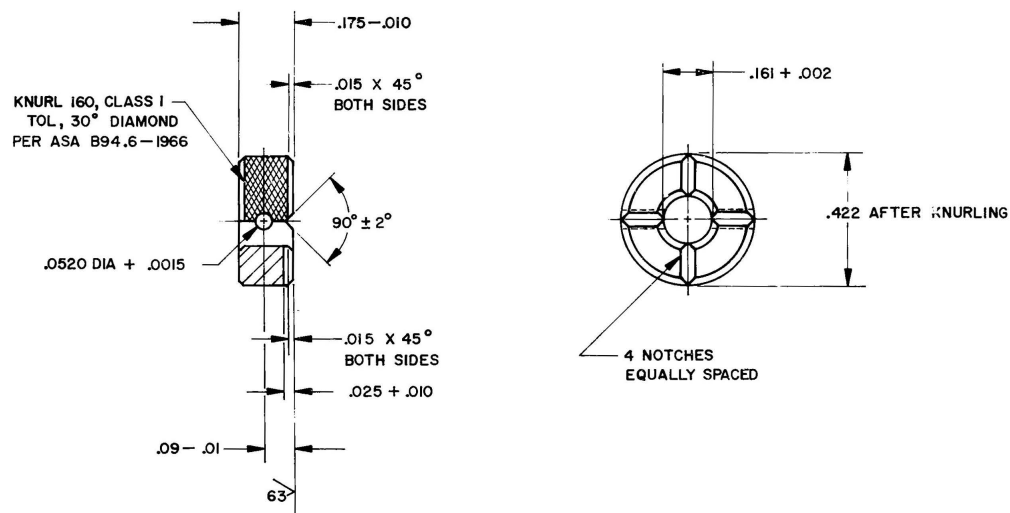
3

2

1

## NOTES:

1.  $\sqrt{125}$  ALL OVER EXCEPT AS NOTED
2. MATERIAL:  
STEEL, COMP III7, III18 OR III12,  
SPEC QQ-S-637.
3. HEAT TREATMENT:  
CARBURIZE AT 1550° TO 1600° F  
FROM .005 TO .010 CASE DEPTH.  
OIL QUENCH. TEMPER 30 MINUTES  
AT 350° F MINIMUM TO HARDNESS  
SPECIFIED. HEAT TREATMENT  
METHOD IS FOR GUIDANCE ONLY  
EXCEPT TEMPERING TIME SHALL  
NOT BE REDUCED BELOW THAT  
SPECIFIED.
4. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OF MIL-STD-171.
5. FILEHARD TEST IN ACCORDANCE  
WITH SA-STD-104. (C1)



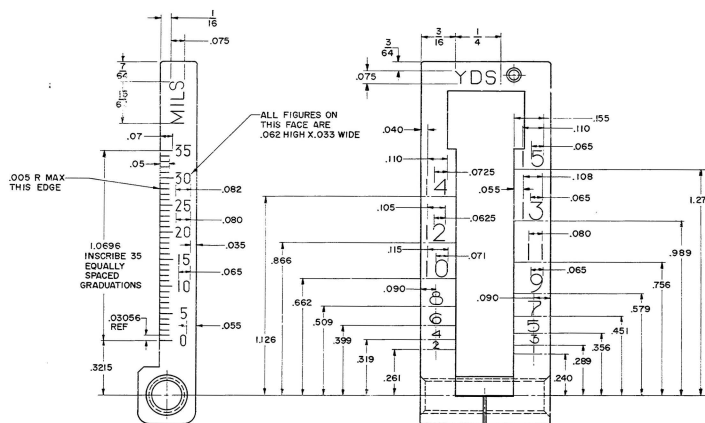
REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED
B	REPLACES REV A W/CHANGE SEE EO RIA-14469	3 NOV 67	S. H. H. H.
C	(1-2) SEE EO RIA-14562	20 DEC 67	R. H. H. H.

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 JUN 39		DEPT OF THE ARMY	
YP		TOLERANCES ON DECIMALS $\pm .015$		DRAFTSMAN E. J. R.		ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
TS		FRACTIONS $\pm$ ANGLES $\pm 1^\circ$		CHECKER E. B.		<b>KNOB, REAR SIGHT ELEVATING SCREW</b>	
EL 2	D5564208 .30 BAR	MATERIAL		TRACER A. COLE			
RA	MI918 A2	SEE NOTE 2		ENGINEER A. COLE			
BH	SEE ENGINEERING RECORDS	HEAT TREATMENT		SUBMITTED			
RH	APPLICATION	SEE NOTE 3		APPROVED		DWG SIZE CODE IDENT NO	
FILEHARD (SF NOTE 5)	APPLY PART NO.	FINAL PROTECTIVE FINISH		A. COLE		C 19204 5152778	
		SEE NOTE 4				SCALE 4/1 UNIT WT SHEET 1 OF 1	



# NOTES

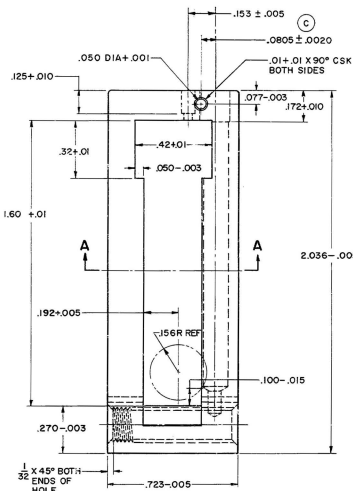
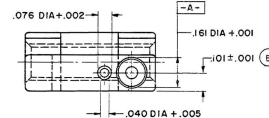
1. FINISH 125/
2. ALL EXTERIOR CORNERS AND EDGES SHALL BE BROKEN .005 ± .020 X 45° OR .003R ± .020 EXCEPT AS NOTED.
3. BREAK EDGES .01 MAX ALONG EDGES OF .32 AND .42 SLOT, BOTH SIDES.
4. MATERIAL:  
STEEL, COMP 1117, 1118 OR B1112, SPEC QQ-S-637.



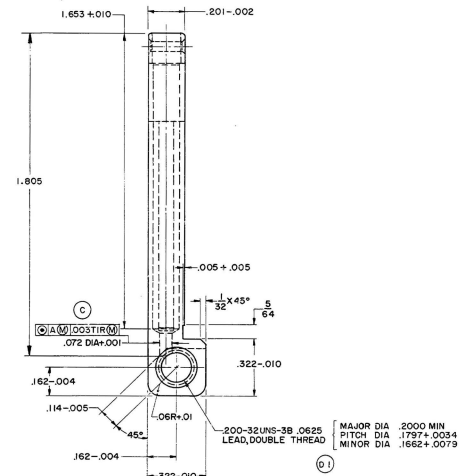
MARKING & GRADUATIONS  
TOLERANCE ON LOCATION OF GRADUATIONS ±.003  
INSCRIBE GRADUATION LINES 80° INCL X .005 ± .005 DEEP  
AND ALL FIGURES & LETTERS 70° INCL X .005 ± .005 DEEP  
SIZE OF FIGURES ON FACE OF LEAF

FIGURE 1 .034 HIGH  
FIGURE 2 .040 HIGH X .040 WIDE  
FIGURE 3 .047 HIGH X .047 WIDE  
FIGURE 4 .047 HIGH X .054 WIDE  
FIGURE 5 TO 6 INCL .063 HIGH X .063 WIDE  
FIGURE 7 TO 8 INCL .076 HIGH X .076 WIDE  
FIGURE 9 TO 15 INCL .094 HIGH X SEE DIMENSIONS FOR WIDTH

INDEX LINES 80° INCL  
X .005 ± .005 DEEP



SECTION A-A



CODE IDENT NO. 19204  
PART NO. 6535422

PROPERTY	VALUE	PROPERTY	VALUE
DESIGNATION	D556420B	APPROVAL	APPROVED
QUANTITY	30 BARM918	DATE	1/64
REVISIONS	SEE ENGINEERING RECORDS	HEAT TREATMENT	SEE NOTE 4
APPROVAL	APPROVED	APPLY PART NO.	APPROVED
DO NOT	DO NOT	FINAL PROTECTIVE FINISH	FINISH 5.3.1.2 OF MIL-STD-171

DATE	1/64	BY	APPROVED
REVISIONS		DATE	APPROVED
1	1/64	2	1/64
3	1/64	4	1/64
5	1/64	6	1/64
7	1/64	8	1/64
9	1/64	10	1/64
11	1/64	12	1/64
13	1/64	14	1/64
15	1/64	16	1/64

DEPT OF THE ARMY  
ROCK ISLAND, ARSENAL  
ROCK ISLAND, ILL. 62001

6535422

SCALE 4/1 UNIT WT. .04

REDUCED SIZE PRINT

C C7312235

C7312235

JOINT — 6147338

TUBE — 6147334

INSCRIBE PART NUMBER 7312235,  
 $\frac{1}{16}$  HIGH PER MIL-STD-130.

C1

D

NOTES:

1. BRAZING ALLOY, FED SPEC QQ-B-650.  
 CLASS FS-BCU

2. HEAT TREATMENT:

HEAT LENGTH  $\ominus$  IN CARBURIZING  
 MEDIUM AT 1550-1600°F TO CASE DEPTH  
 .002 TO .005. HEAT ALL OVER IN NEUTRAL  
 ATMOSPHERE AT 1525-1550°F QUENCH IN  
 OIL. TEMPER ALL OVER AT 350°F FOR 1/2  
 HOUR AT HEAT. RETEMPER TUBE SECTION  
 TO SPECIFIED HARDNESS.  
 HEAT TREATMENT METHOD IS FOR  
 GUIDANCE ONLY EXCEPT TEMPERING TIME  
 SHALL NOT BE REDUCED BELOW THAT  
 SPECIFIED.

3. FINAL PROTECTIVE FINISH:

FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171,  
 EXCEPT PARA 3.3 OF MIL-P-16232  
 SHALL NOT APPLY.

4. HARDNESS:  $\ominus$  FILE HARD  
 LENGTH  $\ominus$  FILE HARD  
 TUBE — ROCK A 70-73

5. MIL-W-13855 APPLIES.

BRAZE PER SPEC MIL-B-7883  
 BRAZED JOINT SHALL WITHSTAND  
 A TORQUE OF 40 LB-FT.  
 (SEE NOTE 1) D

CODE IDENT NO. 19204  
 PART NO. 7312235

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7312235

PHYSICAL PROPERTIES		C7148442	308MGM99A6	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE OF DRAWING	1 JUN 44
YP		D7312239	30BARM99A2	TOLERANCES ON DECIMALS $\pm$	DRAFTSMAN F.C.L.	CHECKER
TS				ANGLES $\pm$	TRACER	157
EL 2				FRACTIONS $\pm$ 1/64	ENGINEER	157
RA					ENGINEER	157
BH					SUBMITTED	
					APPROVED BY	ORD CORPS
RM	SEE NOTES 4 AND 5				CHIEF OF OFFICE	
		DO NOT	APPLY PART NO.	HEAT TREATMENT		
		DO	AS SPECIFIED	SEE NOTE 2		
				FINAL PROTECTIVE FINISH		
				SEE NOTE 3		

D	(6) SEE ERR MQR 20772	22 SEP 72	W. H. H.
C	(1-3) SEE EO RIA-14493	16 NOV 67	W. H. H.
B	REF EO NO. SA 24771	23 OCT 58	W. H. H.
A	REDRAWN AND REVISED	8 MAY 58	W. H. H.
IO	WAS "B" SIZE		
SYN	DESCRIPTION	DATE	APPROVAL
	REVISIONS		

LEG, BIPOD,  
 ASSEMBLY

DEPT OF THE ARMY  
 U.S. ARMY  
 WEAPONS COMMAND  
 ROCK ISLAND, ILL. 61201

7312235

SCALE 1/1 UNIT WT .38

C

ANY RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT THEREBY INCURS NO RESPONSIBILITY FOR ANY OBLIGATION WHATSOEVER; AND THE FACT THAT THE GOVERNMENT MAY HAVE FORMULATED, FURNISHED, OR IN ANY WAY SUPPLIED THE SAID DRAWINGS, SPECIFICATIONS OR OTHER DATA IS NOT TO BE REGARDED BY IMPLICATION OR OTHERWISE AS IN ANY MANNER LICENSING THE HOLDER OR ANY OTHER PERSON OR CORPORATION, OR CONFERRING ANY RIGHTS OR PERMISSION TO MANUFACTURE, USE, OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE RELATED THERETO.

# HEAT TREATMENT AND FINAL FINISH

PROT. FINISH: TYPE I OR II, SPEC ML-C-16232

DO NOT INSCRIBE PART NO.

## PHYSICAL PROPERTIES

Y.P.  
T.S.  
EL.2  
RED.  
BR.  
ROCK.

JUNE 1, 1944

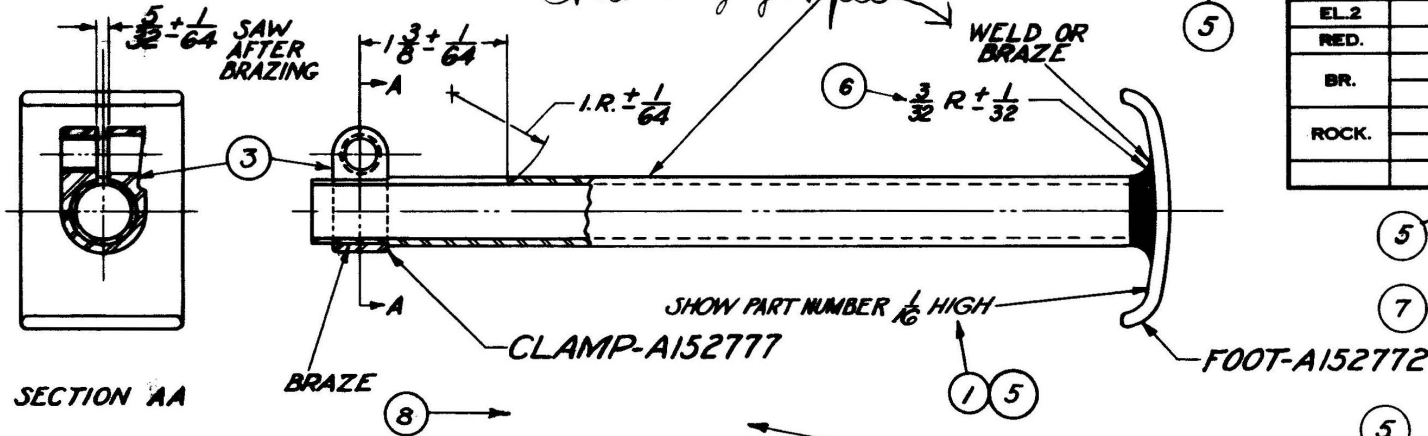
## REVISIONS

1 <sup>3</sup>	8-24-44	9 <sup>2</sup>	19 AUG 45
2 <sup>1</sup>	12-21-44		
3 <sup>2</sup>	1-11-45		
4 <sup>2</sup>	4-30-46		
5 <sup>3</sup>	1-28-48		
6 <sup>1</sup>	1-14-52		
7 <sup>1</sup>	5-21-52		
8 <sup>1</sup>	8-14-52		

## DRG. PERTAINS TO

51-102	30 BAR-M/BAZ
D7312239	BHPD, ASSEM.
CT148442	30 B.M.G.-M79A6

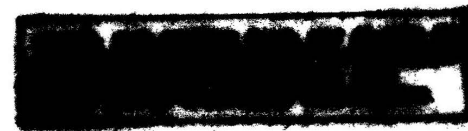
B7312237



## LIST OF COMPONENTS

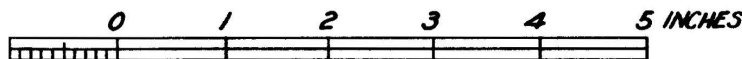
1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NO. REQUIRED PER UNIT ASM.
1	B7312237	LEG, SLIDING, L.H., ASSEMBLY	1
2		COMPOSED OF:	
3	A152777	1-CLAMP, LEG	*
4	A152772	1-FOOT, BIPOD	*
5	A152775	1-TUBE, SLIDING LEG	*
6			

LEG, SLIDING, L.H., ASSEMBLY (7312237)\*



DWG B7266102 APPLIES

\* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.



WITH B7312236 SUPERSEDES B147339

REF. S.A. 16416  
SPRINGFIELD ARMORY

B7312237

DTSMAN	TRACER	L'DS DTSMAN
F.C.L.	L.D.	L.D.C.
CHECKER		CHIEF DTSMAN
F.C.L.		
SUBMITTED:		
<i>[Signature]</i>		
ORD. CH. ORD. DEPT.		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:		
<i>[Signature]</i>		
LT. COL. ORD. DEPT.		
ORDNANCE DEPT., U.S.A.		



4

3

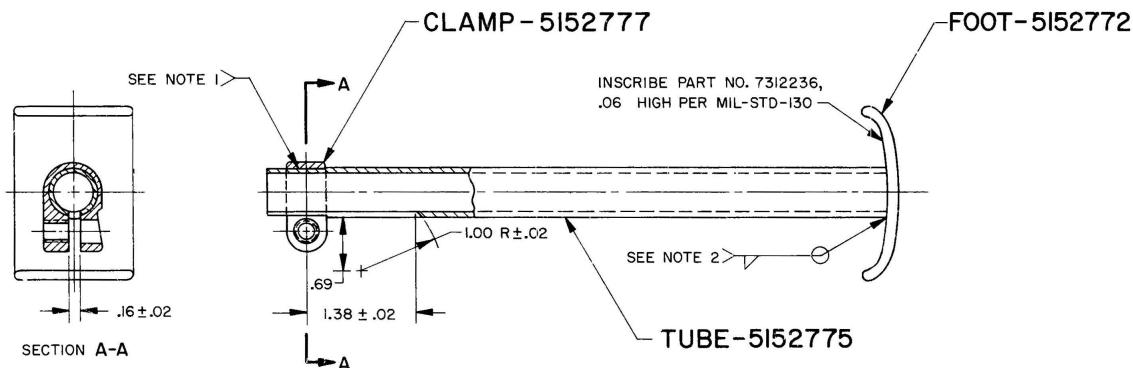
2

1

## NOTES:

1. BRAZE IN ACCORDANCE WITH SPEC QQ-B-650, COMP FS-BCuZn I OR 3 AND MIL-B-7883, TYPE I OR II.
2. WELD IN ACCORDANCE WITH MIL-W-8611 AND MIL-STD-1261.
3. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	REDRAWN & REVISED W/CHG SEE EO 82075	8 APR 68



FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7312236

PART NO. 7312236

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 JUNE 1944		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON	DECIMALS XX ± .01	DRAWINGMAN	FCL	CHECKER	FCL
TS		ANGLES ±	XXX ±	TRACER	A. A. Gorbill	CHECKER	P. E. Heberle
EL 2		MATERIAL		ENGINEER	R. A. Ash	ENGINEER	P. E. Heberle
RA		HEAT TREATMENT		SUBMITTED			
BH	D7312239	30BAR-M18A2		Philip E. Heberle			
RH	C7148442	30BMG-M19A6		APPROVED			
	NEXT ASSY.	USED ON	FINAL PROTECTIVE FINISH	R. S. Henry			
	APPLICATION		SEE NOTE 3				
				DWG SIZE		CODE IDENT NO.	7312236
				C		19204	
				SCALE 1/1		UNIT WT	SHEET 1 OF 1

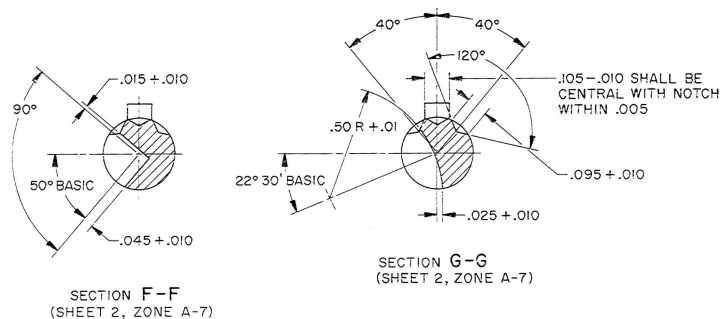
NOTES:  
FINISH ALL OVER  $\sqrt{125}$ .

ALL EDGES SHALL BE BROKEN .003 + .012 UNLESS OTHERWISE SPECIFIED.

MATERIAL:  
STEEL, COMP 4140, SPEC QQ-S-624.

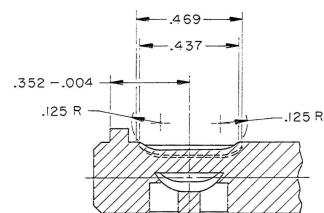
HEAT TREATMENT:  
HEAT AT 1540° TO 1580° F, OIL QUENCH.  
TEMPER AT 400° F MIN FOR 1 HOUR TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE ONLY EXCEPT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.

AFTER BRAZING AND BEFORE ASSEMBLY  
HEAT TREAT BODY TO SPECIFIED HARDNESS.  
TEMPER .250 INCH SMALL END AT APPROX 1200° F.

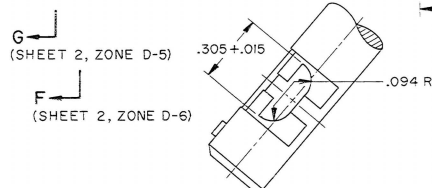
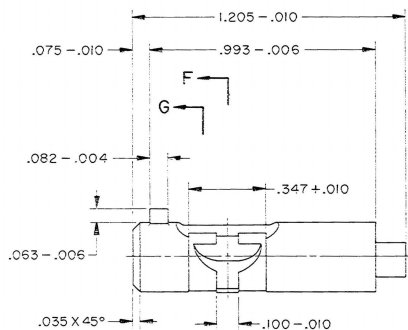


SECTION F-F  
(SHEET 2, ZONE A-7)

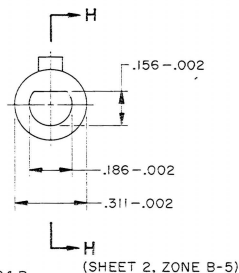
SECTION G-G  
(SHEET 2, ZONE A-7)



PARTIAL SECTION H-H  
(SHEET 2, ZONE A-6)



BODY, LEVER - 4



SECTION J-J  
(SHEET 2, ZONE B-3)

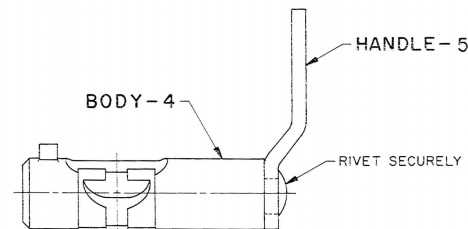
HANDLE, LEVER - 5

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST-5509071

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 7 APR 1943		DEPT OF THE ARMY	
YP		TOLERANCES ON DIMENSIONS	XX ± .015	DRAWN	EJR	CHECKED	FB
TS		ANGLES ± 1°	XXX ± .015	TRACER	Van Kester	CHECKER	SPC
EL 2		MATERIAL	SEE ABOVE	ENGINEER	DH	ENGINEER	LJL
RA		HEAT TREATMENT	SEE ABOVE	SUBMITTED			
BM	F6535469	30 B.A.R.	SEE ABOVE	APPROVED	Philip E. Nebel		
RM	D63-68	NEXT ASSY.	USED ON	APPROVED	R. S. Schumey		
APPLICATION		SEE ABOVE					

REVISIONS			
MF	ZONE	LTR	DESCRIPTION
	B		REDRAWN & REVISED W/CHG
			SEE EO RIA-14488
			DATE 25 JAN 68
			APPROVED

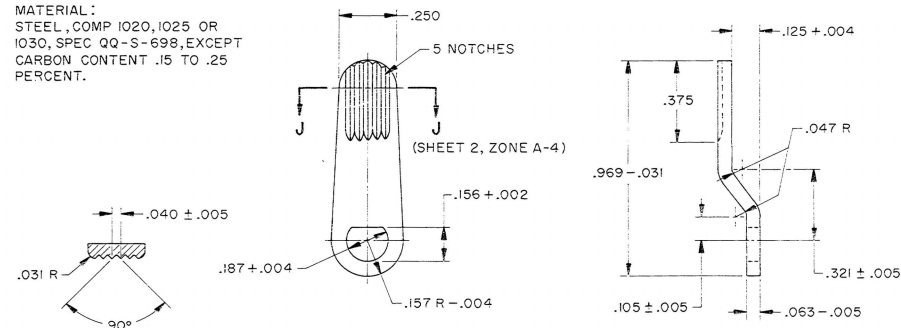
NOTES:  
FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2  
OF MIL-STD-171.



LEVER, CHANGE - I  
(ALTERNATIVE DESIGN - II)

NOTES:  
FINISH ALL OVER  $\sqrt{125}$ .  
ALL EDGES SHALL BE BROKEN  
.003 + .012 UNLESS OTHERWISE  
SPECIFIED.

MATERIAL:  
STEEL, COMP 1020, 1025 OR  
1030, SPEC QQ-S-698, EXCEPT  
CARBON CONTENT .15 TO .25  
PERCENT.



(SHEET 2, ZONE A-4)

PART NO. 5509071

ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201

LEVER, CHANGE

DWG SIZE CODE IDENT NO  
D 19204 5509071

SCALE 4/1 UNIT WT .02 SHEET 2 OF 3

8

7

6

5

4

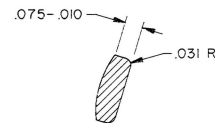
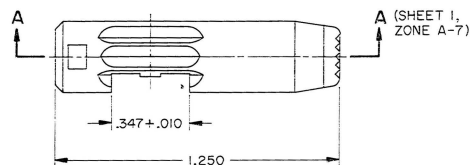
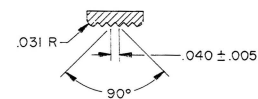
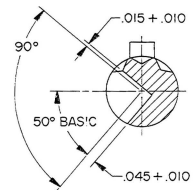
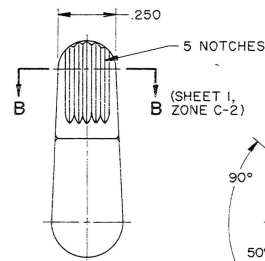
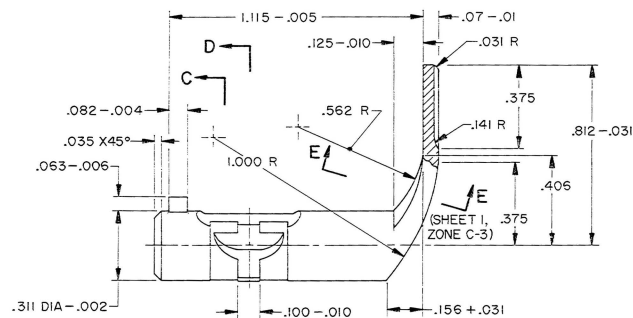
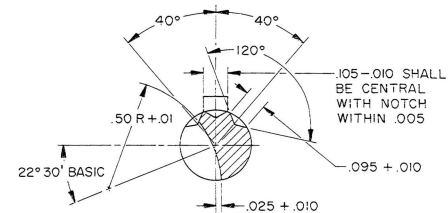
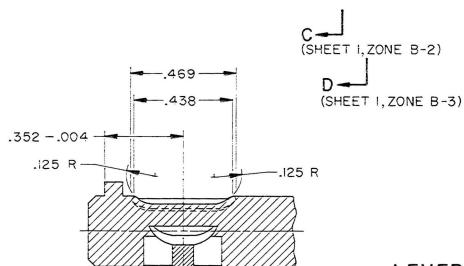
3

2

1

## NOTES:

1. FINISH ALL OVER  $125\sqrt{\text{V}}$ .
2. ALL EDGES SHALL BE BROKEN  $.003 + .012$  UNLESS OTHERWISE SPECIFIED.
3. A. FOR WROUGHT MATERIAL:  
STEEL, COMP 1050, SPEC QQ-S-634.  
B. FOR PRECISION CASTING:  
STEEL, COMP IC 8640, SPEC MIL-S-22141,  
EXCEPT CARBON .40-.50 PERCENT.  
TENSILE TEST SHALL NOT APPLY.
4. HEAT TREATMENT:  
HEAT TO  $1475^{\circ}$  TO  $1500^{\circ}\text{F}$  OIL QUENCH.  
TEMPER TO HARDNESS SPECIFIED. HEAT  
TREATMENT METHOD IS FOR GUIDANCE ONLY.
5. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
6. INSPECTION SHALL BE IN ACCORDANCE  
WITH MIL-C-6021, CLASS 1B, GRADE A.

SECTION E-E  
(SHEET I, ZONE B-5)SECTION B-B  
(SHEET I, ZONE C-4)SECTION D-D  
(SHEET I, ZONE B-6)SECTION C-C  
(SHEET I, ZONE B-6)PARTIAL SECTION A-A  
(SHEET I, ZONE D-6)LEVER, CHANGE  
(ALTERNATIVE DESIGN-1)

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST-5509071

PART NO. 5509071

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 7 APR 1943		DEPT. OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON DECIMALS		DRAWN EJR	CHECKED FB	LEVER, CHANGE	
TS		ANGLES $\pm 1^{\circ}$		DESIGNED J. Van der Grinten	SPECIFIED EJR		
RA		MATERIAL		APPROVED DM	UNLESS L.J.L.		
BH	F6535469	SEE NOTE 3		SUBMITTED			
RM	D63-68	HEAT TREATMENT		APPROVED		DWG. SIZE	CODE IDENT NO.
		SEE NOTE 4				D 19204	5509071
		FINAL PROTECTIVE FINISH				SCALE 4/1	UNIT WT. .02
		SEE NOTE 5				SHEET 1 OF 3	

REDUCED SIZE PRINT

8

7

6

5

4

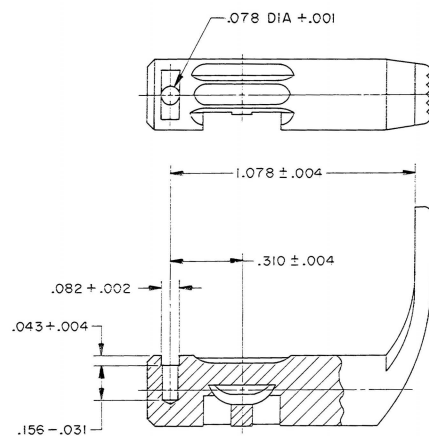
3

2

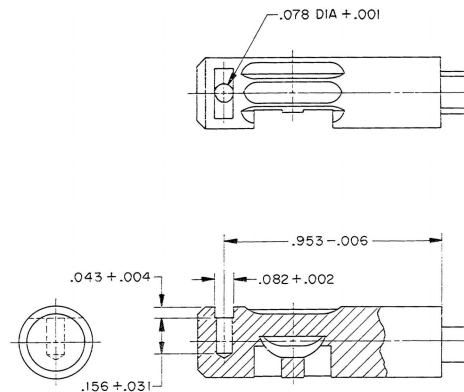
1

REVISIONS				
NO	DATE	DESCRIPTION	BY	APPROVED
1	25 JAN 68	REDRAWN & REVISED W/CHG SEE EO RIA-14488	B	<i>Kendall</i>

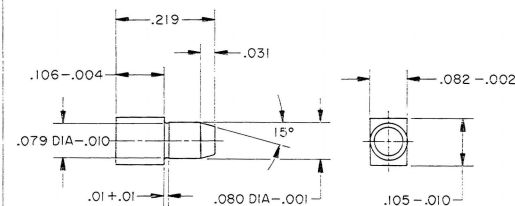
NOTES:  
FINISH ALL OVER  $\sqrt{25}$ .  
ALL EDGES SHALL BE BROKEN .003+.012  
UNLESS OTHERWISE SPECIFIED.  
MATERIAL:  
STEEL, COMP 4140, SPEC QQ-S-624.



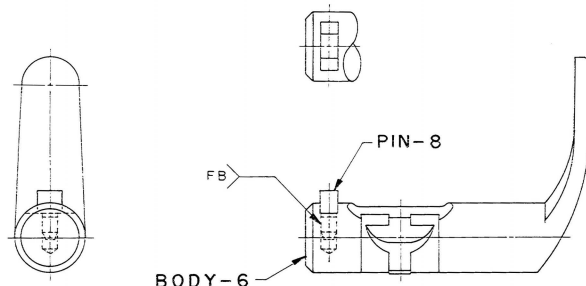
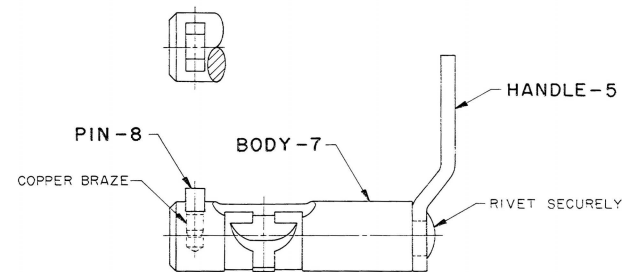
BODY, LEVER-6



BODY, LEVER-7

PIN, LEVER-8  
SCALE 8/1

NOTES:  
BRAZING REQUIREMENTS:  
BRAZE IN ACCORDANCE WITH TYPE II, SPEC  
MIL-B-7883. FILLER METAL BCU-1.  
THE BRAZED JOINT SHALL NOT BE  
SEPARATED BY A PULL TEST OF 50 PSI.  
RADIOGRAPHIC INSPECTION OF BRAZED JOINT  
IS WAIVED IF PULL TEST IS SATISFACTORILY PERFORMED.  
FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.

LEVER, CHANGE-2  
(ALTERNATIVE DESIGN-III)LEVER, CHANGE-3  
(ALTERNATIVE DESIGN-IV)

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST-5509071

PART NO. 5509071

FOR LIST OF PARTS, SEE ENGINEERING PART NO. 5509071		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING		DEPT OF THE ARMY	
MECHANICAL PROPERTIES		TOLERANCES ON DECIMALS ANGLES ± 1° MATERIAL		7 APR 1943		ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 51201	
TP		XX ± .015		DRAWN	EJR	CHECKED	FB
TS		SEE ABOVE		TRACER	Van Houten		
EL 2		HEAT TREATMENT		ENGINEER	DH	CHECKER	LVL
RA		SEE ABOVE		SUBMITTED			
BH	F6535469	.30 BAR, M1918A2		Philip S. Helber			
RM	D63-68	NEXT ASSY. USED ON		APPROVED			
APPLICATION		SEE ABOVE		R.D. Kewey			
				D			
				12904			
				5509071			
				SCALE 4/1			
				UNIT WT .02			
				SHEET 3 OF 3			

REDUCED SIZE PRINT

4

3

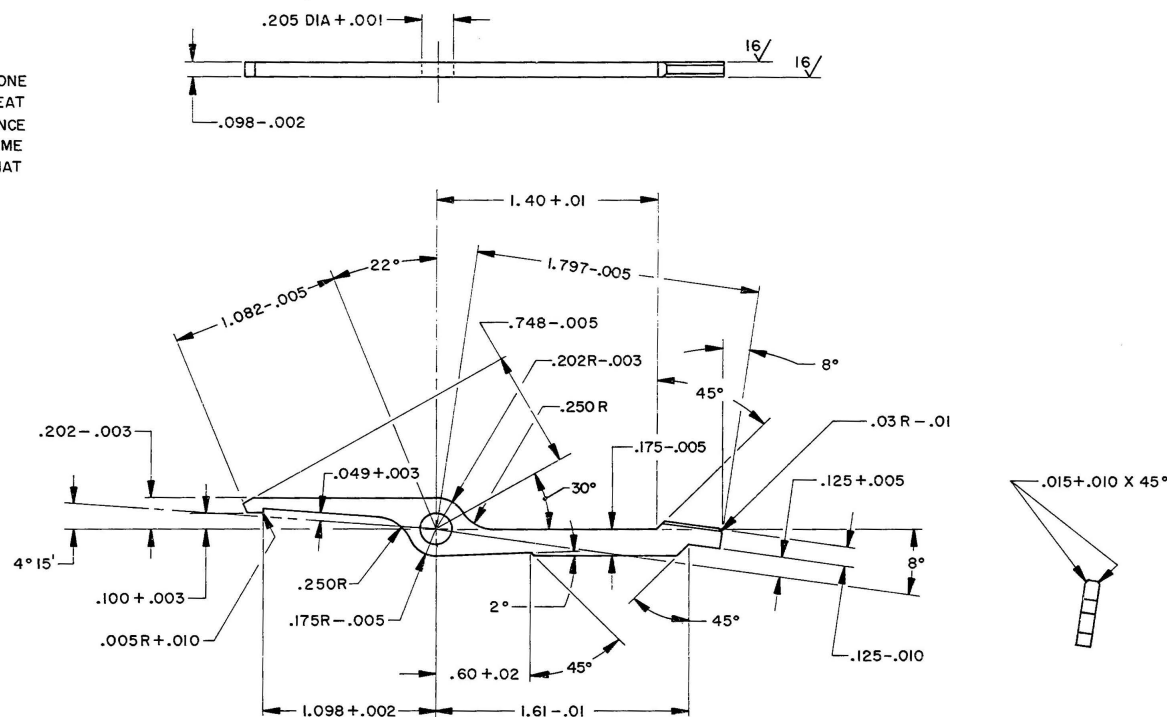
2

1

## NOTES:

1.  $\sqrt{125}$  ALL OVER EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN  
.003+.012 UNLESS OTHERWISE  
SPECIFIED.
3. MATERIAL:  
STEEL, COMP 8645 OR 8742  
PER ASTM A506-64.
4. HEAT TREATMENT:  
HEAT AT 1540° TO 1580°F. OIL  
QUENCH. TEMPER AT 420°F FOR ONE  
HOUR TO HARDNESS SPECIFIED. HEAT  
TREATMENT METHOD IS FOR GUIDANCE  
ONLY EXCEPT THAT TEMPERING TIME  
SHALL NOT BE REDUCED BELOW THAT  
SPECIFIED.
5. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2 OF  
MIL-STD-171.

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	REDRAWN & REVISED W/CHANGE SEE EO RIA-14488	25 JAN 68



PART NO. 6147487

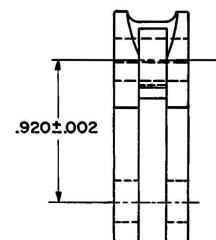
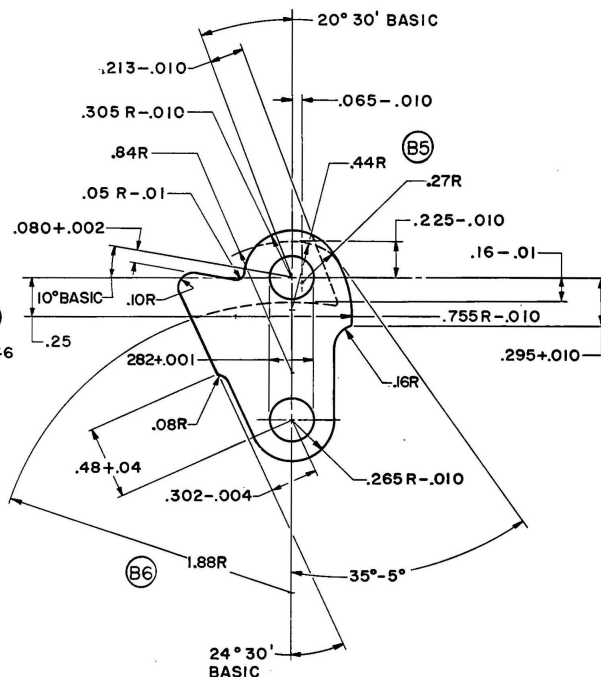
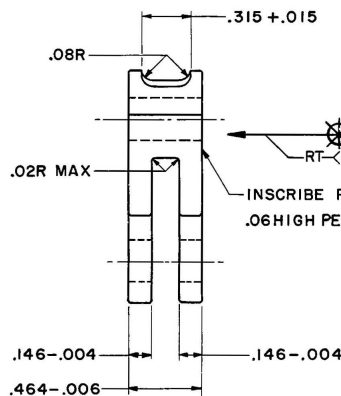
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 5 JUN 1940		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON DECIMALS .XX ±		DRAFTSMAN H. J. O.	CHECKER G. H. G.	LEVER, STOP, SEAR RELEASE	
TS		ANGLES ± 1° XXX ± .015		TRACER Van der Borghe	CHECKER E. J. A.		
EL 2		MATERIAL		ENGINEER G. J. T.	ENGINEER E. J. A.		
RA		SEE NOTE 3		SUBMITTED Philip E. Hebert			
BH	F6535469	30 B.A.R.	HEAT TREATMENT	APPROVED R. S. Henry		DWG SIZE C	CODE IDENT NO. 19204
RH	C54-58	MI918A2	SEE NOTE 4			6147487	
APPLICATION		FINAL PROTECTIVE FINISH	SEE NOTE 5			SCALE 2/1	UNIT WT
						SHEET 1 OF 1	

I. FINISH <sup>125</sup>✓ ALL OVER.

- 
- A diagram showing a circle with center  $B$ . Two radii are drawn from  $B$  to the circumference, forming a central angle. An arc is drawn between the two radii to indicate the angle.

A. FOR WROUGHT MATERIAL:  
STEEL, COMP 1040 OR 8640, SPEC  
QQ-S-624.

- B. FOR INVESTMENT CASTING:  
STEEL, COMPIC 4140 OR IC 8640,  
MIL-S-22141. CLASSIFICATION AND  
INSPECTION OF INVESTMENT CASTINGS  
SHALL BE IN ACCORDANCE WITH CLASS  
2A, GRADE B, MIL-C-6021.



**C 6019646**

4. HEAT TREATMENT:  
HEAT AT 1525°-1575° F FOR ONE  
HOUR.OIL QUENCH.TEMPER ONE  
HOUR AT HEAT TO HARDNESS  
SPECIFIED.HEAT TREATMENT METHOD  
IS FOR GUIDANCE ONLY,EXCEPT  
TEMPERING TIME SHALL NOT BE  
REDUCED BELOW THAT SPECIFIED.

5. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171,  
EXCEPT PARA 3.3 OF MIL-P-16232  
SHALL NOT APPLY.

CODE IDENT NO. 19204  
PART NO. 6019646

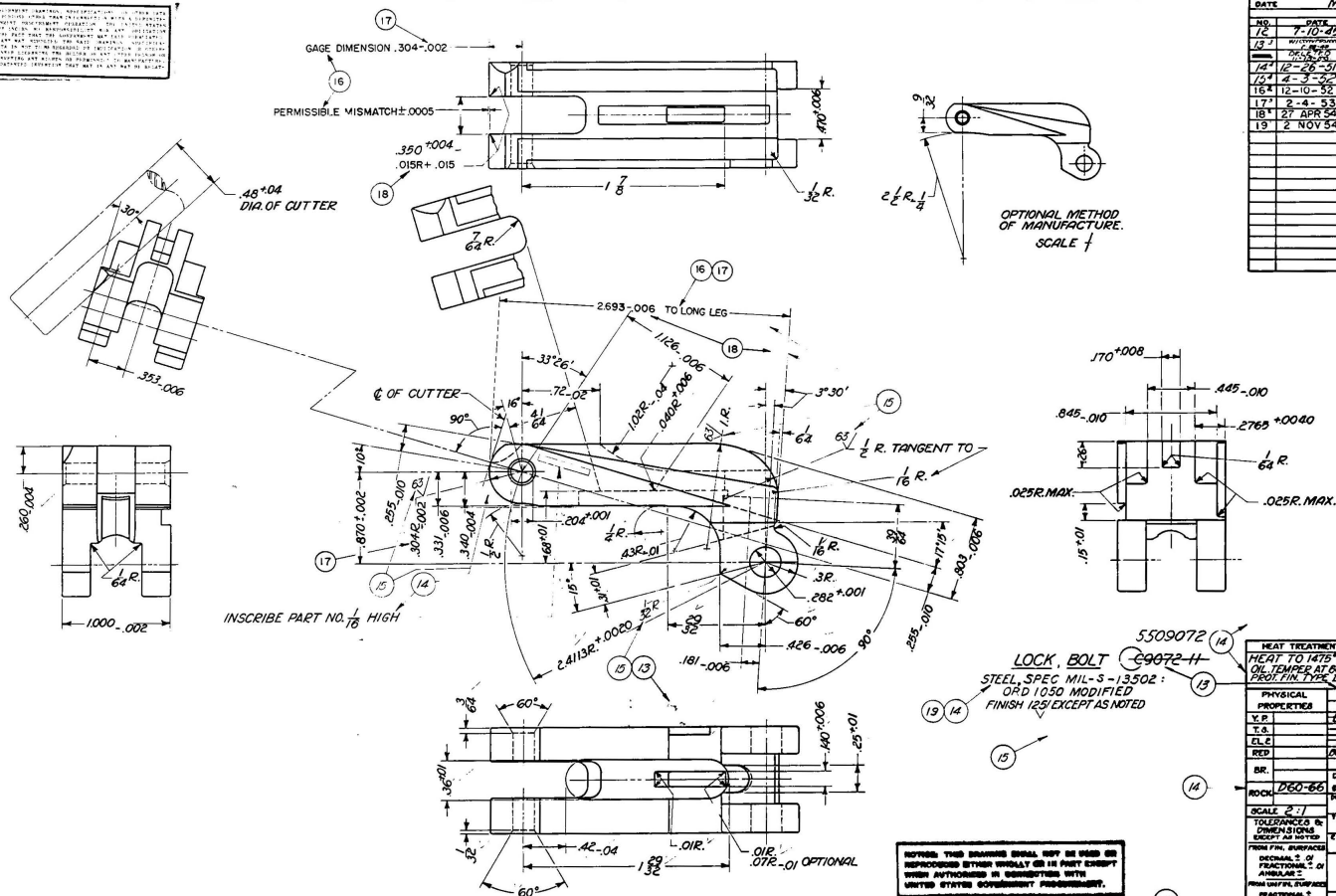
PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE 1 MAY 29		REVISIONS			
TP	F7265703	30BAR MI918	TOLERANCES ON ANGLES $\pm 1^\circ$	DIGITALS $\pm .01$	OF DRAWING	<div>LINK, BOLT</div> <div>DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 61201</div>			
TS		A2	MATERIAL	TRACER R. H. G.	CHECKER [Signature]			<div>DWG NO. 6019646</div> <div>C</div>	
EL 2	SEE ENGINEERING RECORDS		SEE NOTE 3	ENGINEER N. H. G.	ENGINEER [Signature]				
RA			HEAT TREATMENT	SUBMITTED					
BH	NEXT ASSY	USED ON	SEE NOTE 4	ORD CORPS [Signature]					
RH	C46-50	APPLICATION	FINAL PROTECTIVE FINISH	APPROVED BY ORDER OF THE CHIEF OF ORDNANCE [Signature]		SCALE 2/1	UNIT WT .08		
	DO NOT	APPLY PART NO.	SEE NOTE 5						
		AS SPECIFIED							

**F 7265703**

☐ FOR INFORMATION ONLY:  
DWG 12002930 INCLUDES THE SUPPORT EQUIPMENT FOR THE  
RIFLE, M1918A2. THIS EQUIPMENT IS NOT PACKAGED OR  
INCLUDED WITH THE M1918A2 RIFLE, P/N 7265703.

\* CONTAINS ITS OWN ENGINEERING PARTS LIST.

FEDERAL PROPERTIES		EASES FOR PROTECTION GRANTED BY THE GOVERNMENT		ORIGINAL DATE JUNE 9, 1950		REVISONS	
17	TO	TOLERANCES ON DIMENSIONS		DRAWING OF BROWNING, CAL 30		DEPT OF THE ARMY	
18	BY	MATERIALS		DRAWING OF M 1918A2		ROCK ISLAND ARSENAL	
19	FOR	SUBSTITUTION		DRAWING OF LIST OF DRAWINGS		ROCK ISLAND, ILL. 61801	
20	BY	HEAT TREATMENT		DRAWING OF SHOWING REVISIONS IN		REV	
21	FOR	APPLICATION		DRAWING OF EFFECT ON		F	
22	DO	FINAL PROTECTIVE FINISH		DRAWING OF SCALE		UNIT	
23	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
24	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
25	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
26	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
27	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
28	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
29	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
30	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
31	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
32	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
33	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
34	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
35	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
36	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
37	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
38	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
39	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
40	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
41	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
42	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
43	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
44	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
45	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
46	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
47	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
48	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
49	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
50	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
51	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
52	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
53	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
54	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
55	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
56	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
57	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
58	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
59	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
60	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
61	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
62	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
63	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
64	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
65	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
66	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
67	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
68	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
69	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
70	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
71	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
72	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
73	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
74	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
75	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
76	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
77	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
78	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
79	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
80	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
81	DO	APPROVED BY		DRAWING OF SCALE		UNIT	
82	DO	APPROVED BY		DRAWING OF SCALE		UNIT	

[illegible]

0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99
---	---	---	---	---	---	---	---	---	---	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----

SUPERSEDES OLD TRACING C9072 UNDER REVISION DATE OF JULY 10, 1945

DWG. B7266/02 APPLIES

C5509072

[illegible]

*SUPERSEDES C9072*



4

3

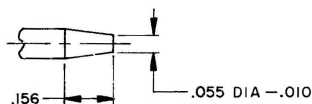
2

1

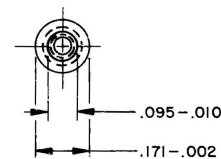
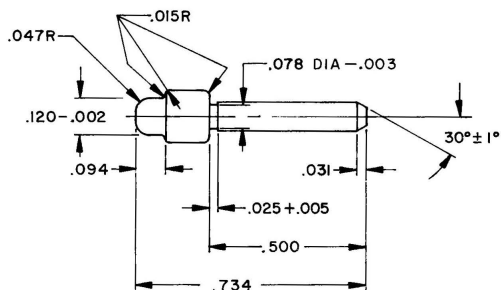
## NOTES:

1. FINISH ALL OVER  $\sqrt{125}$ .
2. ALL EDGES SHALL BE BROKEN  
.003+.012 UNLESS OTHERWISE  
SPECIFIED.
3. MATERIAL:  
STEEL, COMP 1095, SPEC QQ-S-634.
4. HEAT TREATMENT:  
HEAT AT 1425° TO 1475°F. OIL QUENCH.  
TEMPER 30 MINUTES TO HARDNESS  
SPECIFIED. HEAT TREATMENT METHOD  
IS FOR GUIDANCE ONLY EXCEPT  
TEMPERING TIME SHALL NOT BE  
REDUCED BELOW THAT SPECIFIED.
5. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2 OF  
MIL-STD-171.

REVISIONS			
LIR	DESCRIPTION	DATE	APPROVED
A	REDRAWN & REVISED W/CHANGE SEE EO RIA-14488	25 JAN 68	<i>Karvelins</i>

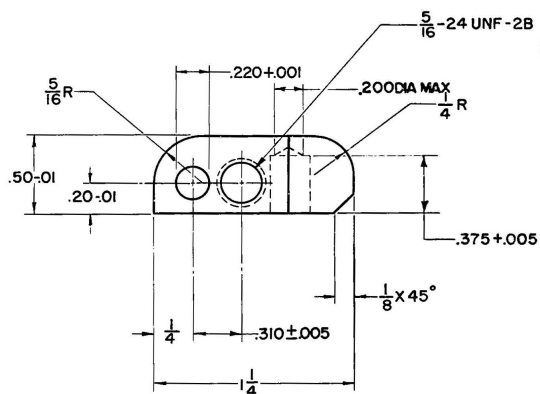
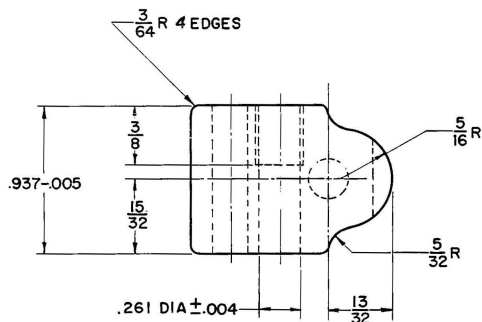


OPTIONAL METHOD

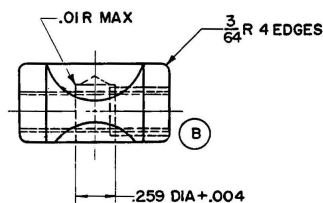


PART NO. 5022225

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 MAY 1929		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON DECIMALS: .015		DRAFTSMAN	CHECKER	LOCK, EJECTOR	
TS		FRACTIONS: ANGLES		E. L. J.	L. S. C.		
EL 2	F6535469	.30 B.A.R.		TRACER	CHECKER		
RA	M1918A2	MATERIAL		ENGINEER	ENGINEER		
BH	SEE ENGINEERING RECORDS	SEE NOTE 3		SUBMITTED			
RH	D56-64	HEAT TREATMENT		APPROVED			
APPLICATION		SEE NOTE 4		Philip E. Hebert			
APPLY PART NO.		FINAL PROTECTIVE FINISH		R. Hebert			
		SEE NOTE 5					
						DWG. SIZE	CODE IDENT NO.
						C	19204
						5022225	
						SCALE 4/1	UNIT WT
						SHEET 1	OF 1



(C1)



(B)

C7313113

NOTES:

1. FINISH ALL OVER 125/
2. MATERIAL:  
STEEL, CMPSN 1018 THRU 1022  
SPEC. QQ-S-631 OR ASTM A576  
OR ASTM A108.
3. MIL-W-13855 APPLIES

(C2)

(D)

(D)

(C3)

CODE IDENT NO. 19204  
PART NO. 7313113

PHYSICAL PROPERTIES		C7313115		RIFLE:		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ±.01 FRACTIONS ± 1/64		ORIGINAL DATE 1 MAY 45 DRAFTSMAN M.E.B. CHECKER J.B.		ROCK ISLAND, ARSENAL	
VT				M1918 A2		MATERIAL		TRACER J.B. CHECKER J.W.		DEPT OF THE ARMY	
TS				BAR		SEE NOTE 2		ENGINEER J.B. ENGINEER J.W.		ROCK ISLAND JLL 61201	
EL 2						HEAT TREATMENT		SUBMITTED		DWS	
RA								ORD CORPS		7313113	
BH		NEXT ASSY USED ON						APPROVED BY ORDER OF THE CHIEF OF BUREAU		C	
RH		APPLICATION		DO NOT APPLY PART NO.		FINAL PROTECTIVE FINISH		SCALE 2/1		UNIT WT .16	
		-AS SPECIFIED-								SHEET 1 OF 1	

LUG

ROCK ISLAND, ARSENAL  
DEPT OF THE ARMY  
ROCK ISLAND JLL 61201

DWS  
7313113

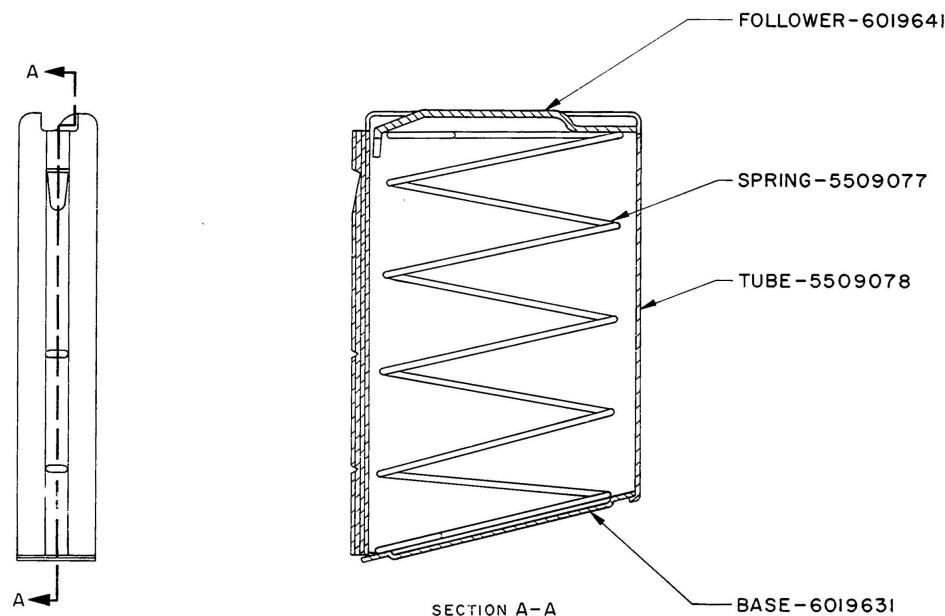
C  
SHEET 1 OF 1

SCALE 2/1 UNIT WT .16

CE

REVISIONS			
SVV	DESCRIPTION	DATE	APPROVAL
17		9 JUN 55	
A	REDRAWN & REVISED SEE EO NO. SA 27570	7 JAN 65	<i>R. S. Henry</i>

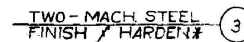
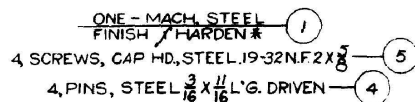
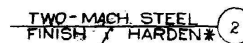
NOTES:  
I. FOR STAMPING OF PART NO. 5564076  
AND MANUFACTURER'S IDENTIFICATION  
MARK SEE DRAWING C6019631.



FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 5564076

PART NO. 5564076

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 JUN 36		SPRINGFIELD ARMOY U. S. ARMY WEAPONS COMMAND SPRINGFIELD 1. MASS. U. S. ARMY MATERIEL COMMAND	
YP		F7265703	.30 BAR-	TOLERANCES ON DECIMALS $\pm$		DRAFTSMAN	CHECKER	MAGAZINE ASSEMBLY	
TS			M1918A2	FRACTIONS $\pm$	ANGLES $\pm$	TRACER	CHECKER		
EL 2		SEE ENGINEERING RECORDS		MATERIAL		ENGINEER	ENGINEER		
RA		NEXT ASSY USED ON		HEAT TREATMENT		SUBMITTED			
BH		APPLICATION				APPROVED		CODE IDENT NO DWG SIZE	
RH		APPLY PART NO SEE NOTE 1		FINAL PROTECTIVE FINISH		C. S. Henry		19205 C 5564076	
DO		AS SPECIFIED						SCALE 1/1 UNIT WT SHEET 1 OF 1	

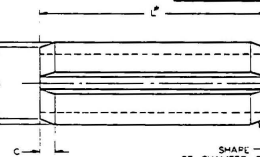
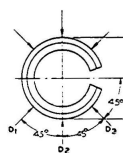


\*HARDEN TO ROCKWELL SCALE C63 MIN.  
LAP <sup>19</sup> SURFACES  
REMOVE ALL SHARP EDGES

[illegible]

DTYMAN <i>AMB</i>	TRACER	LOG DFTYMAN <i>amb</i>
CHECKER <i>CL</i>	CHECKER	CHEF DFTYMAN <i>HC</i>
SUBMITTED: <i>M. F. Kelly</i>		
BY COL. AND DEPT U S A		
APPROVED:		
ORD DEPT U S A		
SPRINGFIELD ARMORY		
DATE SEP T. 21, 1944		
C 5520454		

BFSX2.1



SHAPE OF CHAMFER OPTIONAL

NOMINAL PIN DIAMETER	.062	.078	.094	.125	.156	.187	.219	.250	.312	.375	.500
A DIA OF PIN (Go Ring Groc) (D1+D2+D3)/3	MAX. .069 MIN. .066	.086 .083	.103 .099	.135 .131	.167 .162	.199 .194	.232 .228	.264 .258	.325 .319	.382 .375	.521 .513
B	MAX. .099	.075	.091	.122	.151	.182	.214	.245	.306	.368	.485
C	NOM. .011	.014	.018	.024	.028	.036	.042	.042	.060	.060	.060
STOCK THICKNESS **		.012	.018	.022	.028	.032	.042	.048	.050	.062	.078
RECOMMENDED HOLE SIZE	MAX. .065 MIN. .062	.081 .078	.097 .094	.129 .125	.160 .156	.192 .187	.224 .219	.256 .250	.318 .312	.382 .375	.510 .500
DOUBLE SHEAR STRENGTH-POUNDS	MIN. 425	650	1,000	2,100	3,000	4,400	5,700	7,700	11,500	17,600	25,800

L LENGTH	ORDNANCE PART NUMBER - PHOSPHATE (OILED) FINISH										
1/4	586171	586043	586060								
5/16	586172	586045	586061								
3/8	586173	586046	586062	586077							
1/2	586174	586047	586063	586078							
5/8	586175	586048	586064	586079	586054	586111					
3/4	586176	586049	586065	586080	586055	586112					
7/8	586177	586050	586066	586081	586056	586113					
1 1/8	586178	586051	586067	586082	586057	586114					
1 1/4	586179	586052	586068	586083	586058	586115	586128	586141			
1 3/8	586180	586053	586069	586084	586059	586116					
1 1/2	586181	586054	586070	586085	586060	586117	586129	586142			
1 3/4	586182	586055	586071	586086	586061	586118					
2	586183	586056	586072	586087	586062	586119	586130	586143	586158		
2 1/8	586184	586057	586073	586088	586063	586120	586131	586144			
2 1/4	586185	586058	586074	586089	586064	586121	586132	586145	586159	586171	
2 3/8	586186	586059	586075	586090	586065	586122	586133	586146			
2 1/2					586091	586123	586134	586147	586160	586172	586183
2 3/4					586092	586124	586135	586148	586161	586173	586184
3					586093	586125	586136	586149			
3 1/8					586094	586126	586137	586150			
3 1/4					586095	586127	586138	586151	586162	586174	586185
3 3/8					586096	586128	586139	586152	586163	586175	586186
3 1/2					586097	586129	586140	586153	586164	586176	586187
3 3/4					586098	586130	586141	586154	586165	586177	586188
4					586099	586131	586142	586155	586166	586178	586189
					586100	586132	586143	586156	586167	586179	586190
					586101	586133	586144	586157	586168	586180	586191
					586102	586134	586145	586158	586169	586181	586192
					586103	586135	586146	586159	586170	586182	586193

NOMENCLATURE PATTERN: PIN, SPRING, STEEL, PHOSPHATE (OILED) FINISH, .125 DIA X 1-1/2 LONG; PART NO. 586091, DWG NO. BFSX2.1.  
 MATERIAL: STEEL, PS 1095, HARDNESS ROCK "C" 46-53.  
 FINISH: PHOSPHATE COATING SHALL COMPLY WITH TYPE B, CLASS 2, MIL-Q-12968.  
 TOLERANCES ON LENGTH: ± .015 TO BE USED ON SIZES 0.000 TO 1.000; ± .060 TO BE USED ON SIZES 1.001 TO 2.000; ± .025 TO BE USED ON SIZES 2.001 TO 3.000; ± .030 TO BE USED ON SIZES 3.001 TO 4.000.  
 SPECIFICATION: PINS SHALL BE IN ACCORDANCE WITH MILITARY SPECIFICATION MIL-P-10971 OF LATEST REVISION.  
 \*\*THIS DIMENSION FOR REFERENCE ONLY.

REVISIONS				ORIGINAL DATE OF DRAWING SEP 22, 1950		ORDNANCE ENGINEERING STANDARDS (COMMERCIAL)		ORDNANCE CORPS DEPT OF THE ARMY	
SYM	DESCRIPTION	DATE	APPRO	DRAFTSMAN	CHECKER	PIN, SPRING		ENGINEERING & INSPECTION SECTION - ORDP	
1	NO CHG & SPEC ADDED	3-13-51	R.R.P.	TYPIST	CHECKER				
2	NOTE ADDED	2-15-52	R.R.P.	ENGINEER	ENGINEER				
3	SPEC CHG	6-28-55		SUBMITTED	APPROVED	DIMENSIONS IN INCHES		PREPARED BY ROCK ISLAND ARSENAL	
				MATERIAL					
				STEEL (SEE NOTE)					
						SCALE		BFSX2.1	

NOTES: - THIS GOVERNMENT DRAWING, SPECIFICATIONS, OR OTHER DATA ARE FOR THE USE OF THE UNITED STATES GOVERNMENT ONLY. IT IS THE PROPERTY OF THE UNITED STATES GOVERNMENT AND IS LOANED TO YOUR AGENCY. IT IS NOT TO BE REPRODUCED, COPIED, OR IN ANY MANNER USED FOR OTHER THAN THE PURPOSES FOR WHICH IT WAS ISSUED. IT IS TO BE RETURNED TO THE UNITED STATES GOVERNMENT WHEN NO LONGER NEEDED. IT IS NOT TO BE USED FOR ANY OTHER PURPOSE WITHOUT THE EXPRESS WRITTEN PERMISSION OF THE UNITED STATES GOVERNMENT. IT IS NOT TO BE USED FOR ANY OTHER PURPOSE WITHOUT THE EXPRESS WRITTEN PERMISSION OF THE UNITED STATES GOVERNMENT.

**HEAT TREATMENT & FINAL FINISH**  
HEAT 1425°F-1450°F IN SALT 5 MINUTES. QUENCH IN OIL. TEMPER 1 1/2 HOUR AT HEAT TO OBTAIN ROCKWELL SPECIFIED.  
PROT. FIN. TYPE 1 SPEC MIL-C-16232

~~DO~~ DO NOT INSCRIBE PART NO.

PHYSICAL PROPERTIES

~~A22235~~  
MAY 1, 1929.

REVISIONS

Y. P.	1	6-1-36	6'	4-15-44
T. S.	2'	4-15-38	7'	1-28-45
EL-2	3'	6-1-39	8'	9 JUNE 55
REQ	4'	4-25-42	9'	19 AUG 55
HT. T.	5'	10-12-43		
BR.				
SCL.				
C. C.				
ROCK.				
C45-55				

DRG. PERTAINS TO

51-13-30 BAR-M18  
F7265703 30 BAR-M1918A2

SYMBOL

OAP 1385

DFTSMAN	TRACER	L'DG. DFTSMAN
E. L. J.	B. R.	C. L. C.
CHECKER	CHIEF DFTSMAN	
E. L. J.	E. L. J.	

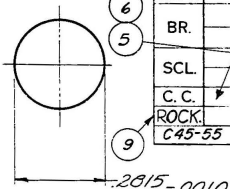
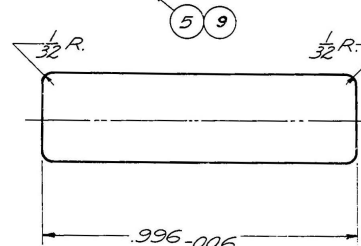
SUBMITTED:

*[Signature]*  
CAPT. ORD. DEPT. U.S.A.

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:

*[Signature]*  
LT COL. ORD. DEPT. U.S.A.

ORDNANCE DEPT. U.S.A.



PIN, BOLT LINK  
STEEL, FED SPEC QQ-S-633; FS 1095  
FINISH ALL OVER 125

TOLERANCE .001 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED  
SUPERSEDES OLD TRACING A22235  
UNDER REVISION DATE OF JUNE 1, 1936  
DWG 87266102 APPLIES

SCALE 1/4"

A5022235

~~A22235~~

SUPERSEDES A22235

A5022235

A5022226

A22226

MAY 1, 1929,

**HEAT TREATMENT & FINAL FINISH**  
 HEAT TO 1425°F.-1450°F. QUENCH IN OIL. TEMPER  
 AT 650°F. 15 MINUTES AT HEAT. TEMPER ABOUT  
 1/16 OF SMALL END AT APPROX. 1200°F. FOR  
 SLIGHT HEADING AT ASSEMBLY.  
**PROT. FIN. TYPE I SPEC MIL-C-16232**

~~DO~~  
 DO NOT INSCRIBE PART NO.

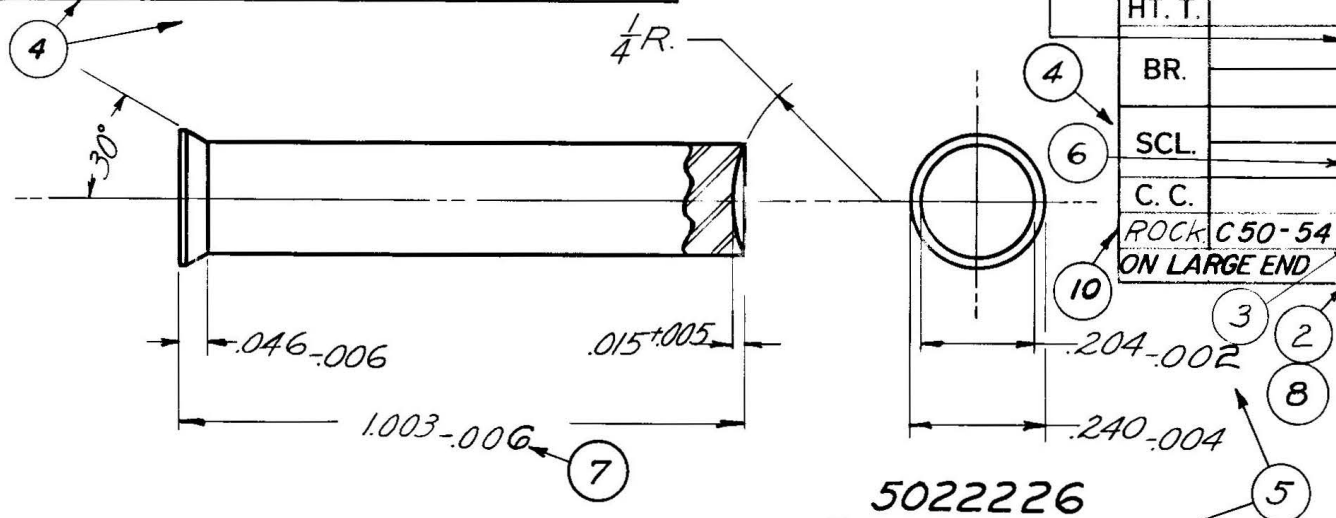
PHYSICAL  
 PROPERTIES

REVISIONS			
1	6-1-36	6 <sup>3</sup>	10-12-43
2 <sup>2</sup>	4-15-38	7 <sup>2</sup>	1-24-44
3 <sup>2</sup>	6-1-39	8 <sup>1</sup>	4-15-44
4 <sup>3</sup>	2-8-41	9 <sup>2</sup>	CONVERSION 1-28-49
5 <sup>1</sup>	6-13-41	10 <sup>3</sup>	19 AUG 50

Y. P.	
T. S.	
EL:2	
RED.	
HT. T.	

BR.	
SCL.	
C. C.	
ROCK C50-54	
ON LARGE END	

DRG. PERTAINS TO	
B19695	BOLT, ASSEMBLY
51-13	30 BAR-M-18
86019695	
51-102	30 BAR-M1918A2



**5022226**  
PIN, BOLT LOCK  
 STEEL, FED SPEC QQ-S-633 FS 1095  
 FINISH ALL OVER 125/

TOLERANCE ±.01 ALLOWED ON ALL DIMEN-  
 SIONS UNLESS OTHERWISE SPECIFIED.

SUPERSEDES OLD TRAGING A22226  
 UNDER REVISION DATE OF JUNE 1, 1936

DWG B7266102 APPLIES

SCALE 4/1

A5022226

A22226

SYMBOL		
OAP1376		
D'FTSMAN E. L. J.	TRACER J. R.	L'D'G D'FTSMAN A. J. C.
CHECKER L. S. B.	CHIEF D'FTSMAN E. J. C.	
SUBMITTED		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:		
S. J. Spaulding LT COL ORD. DEPT. USA		
ORDNANCE DEPT. USA		

SUPERSEDES A22226

NOTES:

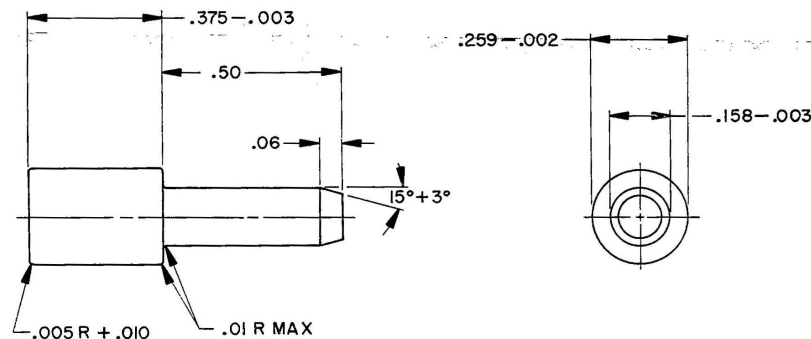
1. FINISH ALL OVER  $\sqrt{125}$ .

2. MATERIAL:

STEEL, CMPSN 1018 THRU 1022,  
SPEC, QQ-S-631 OR ASTM A576  
OR ASTM A108.

3. MIL-W-13855 APPLIES.

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		B	REDRAWN & REVISED W/CHANGE	21 DEC 67
			SEE EO RIA-14535	
		C	(2) SEE ERR HQR 50627	25 MAR 75



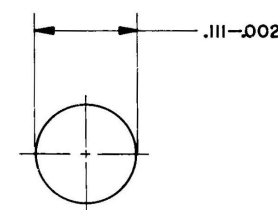
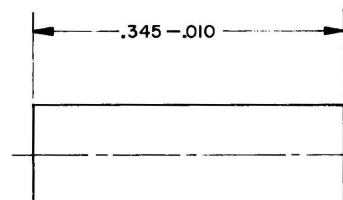
PART NO. 7313116

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 MAY 45		DEPT OF THE ARMY	
YP		TOLERANCES ON DECIMALS .XX ± .02		DRAFTSMAN M.E.B.	CHECKER A.A.C.	ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
TS		ANGLES ± 1° .XXX ±		TRACER C.P. Rader	CHECKER	PIN, BUTT PLATE	
EL 2		MATERIAL SEE NOTE 2		ENGINEER A. COLE	ENGINEER R. HENRY	DWG SIZE B CODE IDENT NO. 7313116	
RA	C7313115	HEAT TREATMENT		SUBMITTED Philip E. Heberle		SCALE 4/1 UNIT WT SHEET OF	
BH		NEXT ASSY. USED ON		APPROVED R. L. Henry			
RH		APPLICATION		FINAL PROTECTIVE FINISH			



NOTES:

1. FINISH ALL OVER  $\sqrt{125}$ .
2. ALL EDGES SHALL BE BROKEN .003  
+ .012 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL:  
STEEL, COMP 1095, SPEC QQ-S-634.



PART NO. **5022229**

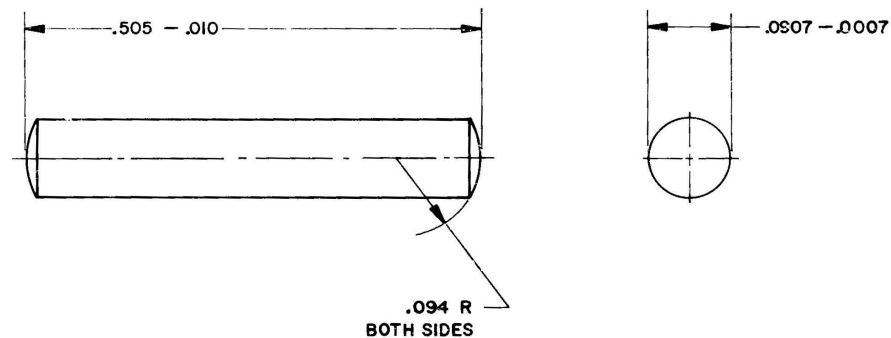
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		C6019684	.30 B A R	TOLERANCES ON DECIMALS ±	DRAFTSMAN	CHECKER	PIN, CONNECTOR
TS			M1918A2	FRACTIONS ± ANGLES ±	E. L. J.	L. S. Giff	
EL 2		SEE ENGINEERING RECORDS		MATERIAL	TRACER	CHECKER	
RA		NEXT ASSY USED ON		SEE NOTE 3	E. W. S.	F. J. C.	
BH		APPLICATION		HEAT TREATMENT	SUBMITTED		DWG SIZE
RH		APPLY PART NO.		FINAL PROTECTIVE FINISH	APPROVED		CODE IDENT NO.
					Philip E. Hebert		B
					R. J. Heaney		19204
							5022229
							SCALE 10/1
							UNIT WT
							SHEET 1 OF 1

SWESP FORM NO. 1176-3  
20 MAR 64 REV.

NOTES:

1. FINISH ALL OVER  $\frac{125}{\sqrt{ }}$ .
2. ALL EDGES SHALL BE BROKEN .003 + .012 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL:  
STEEL, COMP 1095, SPEC QQ-S-634.
4. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OF MIL-STD-171.

REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED
A	REDRAWN & REVISED W/CHANGE SEE EO RIA-14563	20 DEC 1967	<i>P. Hebert</i>



PART NO. 5022230

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 MAY 1929		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL 61201	
YP		D6508769	.30 B.A.R.	TOLERANCES ON FRACTIONS ±	DECIMALS ± .015	DRAFTSMAN E. L. J.	CHECKER L. S. C.
TS			M1918A2	MATERIAL	SEE NOTE 3	TRACER C. R. D.	CHECKER
EL 2		SEE ENGINEERING RECORDS		HEAT TREATMENT		ENGINEER T. J. C.	ENGINEER E. W. S.
RA		NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH	SEE NOTE 4	SUBMITTED <i>Philip E. Hebert</i>	
BH		APPLICATION				APPROVED <i>R. J. Henry</i>	
RH	A70 - 73	APPLY PART NO.				DWG SIZE B	CODE IDENT NO. 19204
						5022230	
						SCALE 10/1	UNIT WT
						SHEET 1	OF 1

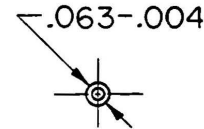
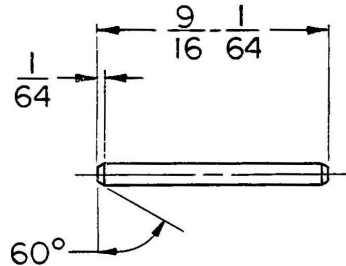
[illegible]

NOTES:

1. STEEL, CMPSN 1020, ASTM A108.

2. FINISH  $\sqrt[125]{}$  ALL OVER.

3. MIL-W-13855 APPLIES.

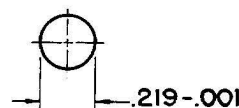
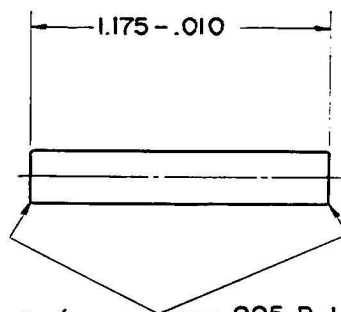


PART NO. 7313466

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING	DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YS MIN		TOLERANCES ON	DECIMALS	24 OCT 45	PIN, GAS PISTON	
YS MAX		ANGLES $\pm 5^\circ$	XX $\pm .01$ XXX $\pm$ —			
EL 2		MATERIAL	SEE NOTE 1	ENGINEER	7313466	
RA	D7313467	RIFLE, CAL. 30		SUBMITTED		
BH		M1918A2 (BAR)		APPROVED	DWG SIZE	
RH		APPLICATION	FINAL PROTECTIVE FINISH FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171		CODE IDENT NO.	
		NEXT ASSY.	USED ON		B 19204	
					7313466	
					SCALE 4/1	
					UNIT WT	
					SHEET 1 OF 1	

001 2102200, 12400

PHYSICAL PROPERTIES		A 5013746		
TP				
TS				
EL 2		REVISIONS		
RA		SYM	DESCRIPTION	DATE
		9		11 DEC 52
BN		A	REDRAWN AND REVISED	1 MAY 58 <i>R. Henry</i>
RM				



FINISH ALL OVER 125/

FINAL PROTECTIVE FINISH:  
FINISH NO. 5.3.1 OR 5.3.3 OF  
MIL-STD-171

DWG B7266102 APPLIES

ORD PART NO. 5013746

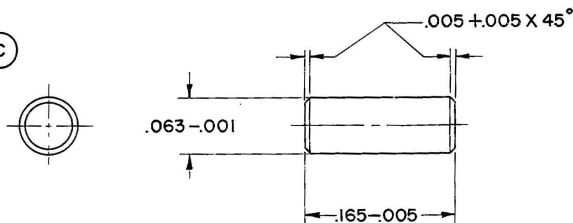
APPLICATION		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE 21 FEB 35	PIN, HINGE	SPRINGFIELD ARMORY ORDNANCE CORPS DEPT OF THE ARMY SPRINGFIELD 1, MASS.
NEXT ASSY	USED ON				
SEE ENGINEERING RECORDS		TOLERANCES ON—	DRAFTSMAN E.O.M. CHECKER <i>J. G.</i>	DWG SIZE A 5013746	SHEET 1 OF 1
C7313114	30 BARMIS18	DECIMALS ± .01	TRACER <i>R. P.</i> CHECKER <i>J. G.</i>		
	A2	FRACTIONS ± 1/64	ENGINEER <i>R. Henry</i>		
		ANGLES ± 1°	SUBMITTED <i>V. J. Lusk</i> ORD CORPS		
MATERIAL STEEL FED SPEC QQ-S-633: C 1095		HEAT TREATMENT	APPROVED BY ORDER OF THE CHIEF OF ORDNANCE <i>A. J. Lusk</i> ORD CORPS	SCALE 2/1	UNIT WT .01
DO NOT	APPLY PART NO.	FINAL PROTECTIVE FINISH SEE NOTE			
DO	AS SPECIFIED				

CE

NOTICE: THIS DRAWING SHALL NOT BE USED  
REPRODUCED EITHER WHOLLY OR IN PART EXCEPT  
WHEN AUTHORIZED IN CONNECTION WITH  
UNITED STATES GOVERNMENT PROCUREMENT.

NOTES:

1. STEEL, CMPSN 1320 THRU 1335,  
SPEC ASTM A331 OR STEEL,  
CMPSN 1010 THRU 1020, SPEC,  
QQ-S-631 OR ASTM A108.
2. FINISH  $\sqrt[125]{}$  ALL OVER.
3. FINISH 5.3.1.2 OR 5.3.22 OF  
MIL-STD-171.
4. MIL-W-13855 APPLIES.



680997LB

(B)

B7266089

CODE IDENT NO. 19204 (C)  
PART NO. 7266089

C	(3) SEE ERR HQR 50616	25 FEB 75	80/1/1/1
B	REF EO NO. SA 24549	15 DEC 59	80/1/1/1
A	SUPERSEDES A7266089 WO/C	27 MAY 55	80/1/1/1
SYM	DESCRIPTION	DATE	APPROVAL

PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 23 MAY 1951		PIN, LOCK, PLUNGER		DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 61201 DWG SIZE B 7266089 SHEET 1 OF 1	
YP		TOLERANCES ON DECIMALS $\pm .01$		DRAFTSMAN <i>PRH</i> CHECKER <i>PRH</i>					
TS		ANGLES $\pm 1^\circ$ FRACTIONS $\pm 1/64$		TRACER <i>PRH</i> CHECKER <i>PRH</i>					
EL2	C7267816	MATERIAL 30 BAR, M1918A2		ENGINEER <i>PRH</i> ENGINEER <i>PRH</i>					
RA		SEE NOTE 1		SUBMITTED <i>PRH</i> ORG CORPS					
BH		HEAT TREATMENT		APPROVED BY ORDER OF THE CHIEF OF ORDNANCE <i>PRH</i> LT. COL. ORG CORPS					
RH		APPLICATION		FINAL PROTECTIVE FINISH					
	DO NOT	APPLY PART NO.		SEE NOTE 3					

5	4	3	2	1		
<b>NOTES:</b> 1. FINISH ALL OVER $\sqrt{125}$ . 2. MATERIAL: STEEL, COMP 1095, SPEC QQ-S-634. 3. HEAT TREATMENT: HEAT AT 1425° TO 1475° F. OIL QUENCH. TEMPER 30 MINUTES TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE ONLY EXCEPT TEMPERING SHALL NOT BE REDUCED BELOW THAT SPECIFIED. 4. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.			<b>REVISIONS</b>			
			LTR	DESCRIPTION	DATE	APPROVED
			A	REDRAWN & REVISED W/ CHANGE SEE EO RIA - 14488	25 JAN 68	<i>Kensler</i>
<b>PART NO. 5022238</b>						
<b>MECHANICAL PROPERTIES</b>		<b>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES</b>		<b>ORIGINAL DATE OF DRAWING</b>		
YP <b>F6535469 .30 B.A.R.</b> TS <b>M1918 A2</b> EL 2 <b>SEE ENGINEERING RECORDS</b> RA <b>SEE ENGINEERING RECORDS</b> BH <b>SEE ENGINEERING RECORDS</b> RH <b>C45-55</b>		TOLERANCES ON DECIMALS ± .015 FRACTIONS ± ANGLES ± MATERIAL <b>SEE NOTE 2</b> HEAT TREATMENT <b>SEE NOTE 3</b> FINAL PROTECTIVE FINISH <b>SEE NOTE 4</b>		<b>MAY 1929</b> DRAFTSMAN <b>E.L.J.</b> CHECKER <b>S.S.C.</b> TRACER <b>T. Ring</b> CHECKER <b>E.H.</b> ENGINEER <b>T.J.C.</b> ENGINEER <b>E.W.S.</b> SUBMITTED <b>Philip E. Hebert</b> APPROVED <b>R.S. Henry</b>		
DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201		<b>PIN, MAGAZINE CATCH PIN, TRIGGER</b>		DWG SIZE <b>B</b> CODE IDENT NO. <b>19204</b> <b>5022238</b>		
SCALE <b>4/1</b> UNIT WT SHEET <b>1</b> OF <b>1</b>		SCALE <b>4/1</b> UNIT WT SHEET <b>1</b> OF <b>1</b>		SCALE <b>4/1</b> UNIT WT SHEET <b>1</b> OF <b>1</b>		

SWESP FORM NO. 1176-3  
20 MAR 64 REV.



NOTICE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

HEAT TREATMENT & FINAL FINISH  
HEAT 1425°F - 1450°F IN SALT 5 MINUTES. QUENCH IN OIL. TEMPER 1/2 HOUR AT HEAT TO OBTAIN ROCKWELL SPECIFIED.  
PROT. FIN. TYPE I OR II SPEC MIL-C-16232

~~DO~~  
DO NOT INSCRIBE PART NO.

PHYSICAL PROPERTIES

MAY 1, 1929

REVISIONS

Y. P.	1	6-1-36	6'	4-15-44
T. S.	2'	4-15-38	7 <sup>3</sup>	CONVERSION 1-28-49
EL-2	3 <sup>2</sup>	6-1-39	8'	JUNE 55
RED.	4 <sup>2</sup>	10-4-43	9 <sup>3</sup>	19 AUG 55
HT. T.	5 <sup>3</sup>	10-12-43		

DRG. PERTAINS TO

BR.	51-13	30 BAR M18
SCL.		
C. C.	3	F7265703 30BAR-M1918A2
ROCK.	8	
		C45-55

SYMBOL

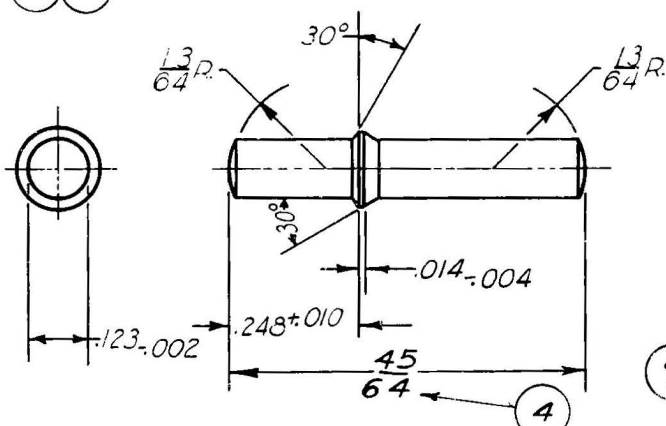
OAP 1386

D'FTSMAN	TRACER	L'D'G. D'FTSMAN
E. L. J.	BNA	O. J. C.
CHECKER	H. E. A.	CHIEF D'FTSMAN
L. S. C.	Edm	SA 100

SUBMITTED:  
*[Signature]*  
CAPT. ORD. DEPT. U.S.A.

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:-  
*[Signature]*  
LT. COLL. ORD. DEPT. U.S.A.

ORDNANCE DEPT. U.S.A.



PIN, OPERATING HANDLE PLUNGER

STEEL, FED SPEC QQ-S-633 FS 1095  
FINISH ALL OVER 125/

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.  
SUPERSEDES OLD TRACING A22236  
UNDER REVISION DATE OF JUNE 1, 1936  
DWG 87266102 APPLIES

SCALE 4/1

A5022236

A22236

SUPERSEDES A22236

A5022236

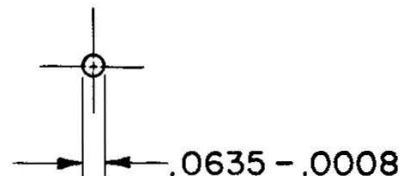
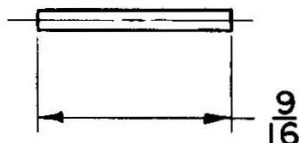
NOTICE.—When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility nor any obligation whatsoever; and the fact that the Government may have formulated, furnished, or in any way supplied the said drawings, specifications or other data is not to be regarded by implication or otherwise as in any manner licensing the holder or any other person or corporation, or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.

PHYSICAL PROPERTIES		DO NOT DO	APPLY PART NO. AS SPECIFIED	REVISIONS			
YP		APPLICATION		SYM	DESCRIPTION	DATE	APPROVAL
TS		NEXT ASSY	USED ON	26	←	19 APR 54	
EL2		SEE ENGINEERING RECORDS		A	REDRAWN AND REVISED	19 DEC 58	<i>R. Henry</i>
RA				B	REF EO SA 26783	14 APR 64	<i>R. Henry</i>
BH				C	SEE EO RIA-14469	3 NOV 67	<i>B. Heberle</i>
RH							
		F6535423	.30 BAR				
			MI918 A2				
			SEE NOTE				

## APPLICATION:

D7267937 - .50 BMG-M2 HB FLEX., FXD

F 7162946 - .30 MG - M37

C 5564906 .30 BMG-M19A4 FLEX., FXD;  
M19A6

(B)

FOR NEW DESIGN WORK  
AND PROCUREMENT USE  
PART NO. MS 39086-56

FINISH ALL OVER <sup>125/</sup>✓

MATERIAL: STEEL, FED SPEC QQ-S-633:

C1020, C1018, C1021, C1022,

C1117, STEEL, FED SPEC QQ-S-00779:

CLASS FS-WI-10

CODE IDENT NO. 19204

DWG B7266102 APPLIES

PART NO. 5013700



UNLESS OTHERWISE SPECIFIED	ORIGINAL DATE OF DRAWING 30 APR 34		PIN, REAR SIGHT WINDAGE KNOB	DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL 61201
	DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS DECIMALS ANGLES ± 1/64 ± .01	DRAFTSMAN MCS CHECKER <i>o.g.c.</i>		
MATERIAL SEE NOTE	TRACER <i>pp</i> CHECKER <i>o.g.c.</i>	ENGR <i>A. Cole</i> ENGR <i>A. Cole</i>	SCALE 2 / 1	DWG SIZE A
HEAT TREATMENT	SUBMITTED <i>R. S. Henry</i> ORD CORPS			
FINAL PROTECTIVE FINISH	APPROVED BY ORDER OF THE CHIEF OF ORDNANCE <i>H. J. Lynde</i> ORD CORPS		UNIT WT	5013700
			SHEET 1	OF 1



A22228

A5022228

HEAT TREATMENT & FINAL FINISH

PROT. FIN. TYPE I OR II SPEC MIL-C-16232

~~DO~~ INSCRIBE PART NO.  
DO NOT

PHYSICAL  
PROPERTIES

MAY 1, 1929

REVISIONS

Y. P.	
T. S.	
EL-2	
RED.	
HT. T.	
BR.	
SCL.	
C. C.	

1	6-1-36	6'	4-15-44
2 <sup>2</sup>	4-15-38	7 <sup>3</sup>	CONVERSION 1-28-49
3 <sup>2</sup>	6-1-39	8 <sup>2</sup>	19AUG55
4'	6-25-40		
5 <sup>3</sup>	10-12-43		

DRG. PERTAINS TO			
<del>D-8770</del>	<del>RECEIVER, ASSEMBLY.</del>		
<del>51-13-30</del>	<del>B.A.R. M-18</del>		
<del>51-102</del>	<del>30 B.A.R. M1918A2</del>		
<del>D35472</del>	<del>RECEIVER, AS'M</del>		
<del>D653572</del>			

SYMBOL

OAP 1378

D'FTSMAN E. L. J.	TRAGER <i>[Signature]</i>	L'D'G. D'FTSMAN O. J. C.
CHECKER L. S. B.	SA O. G. G.	CHIEF D'FTSMAN SA M. B. G.

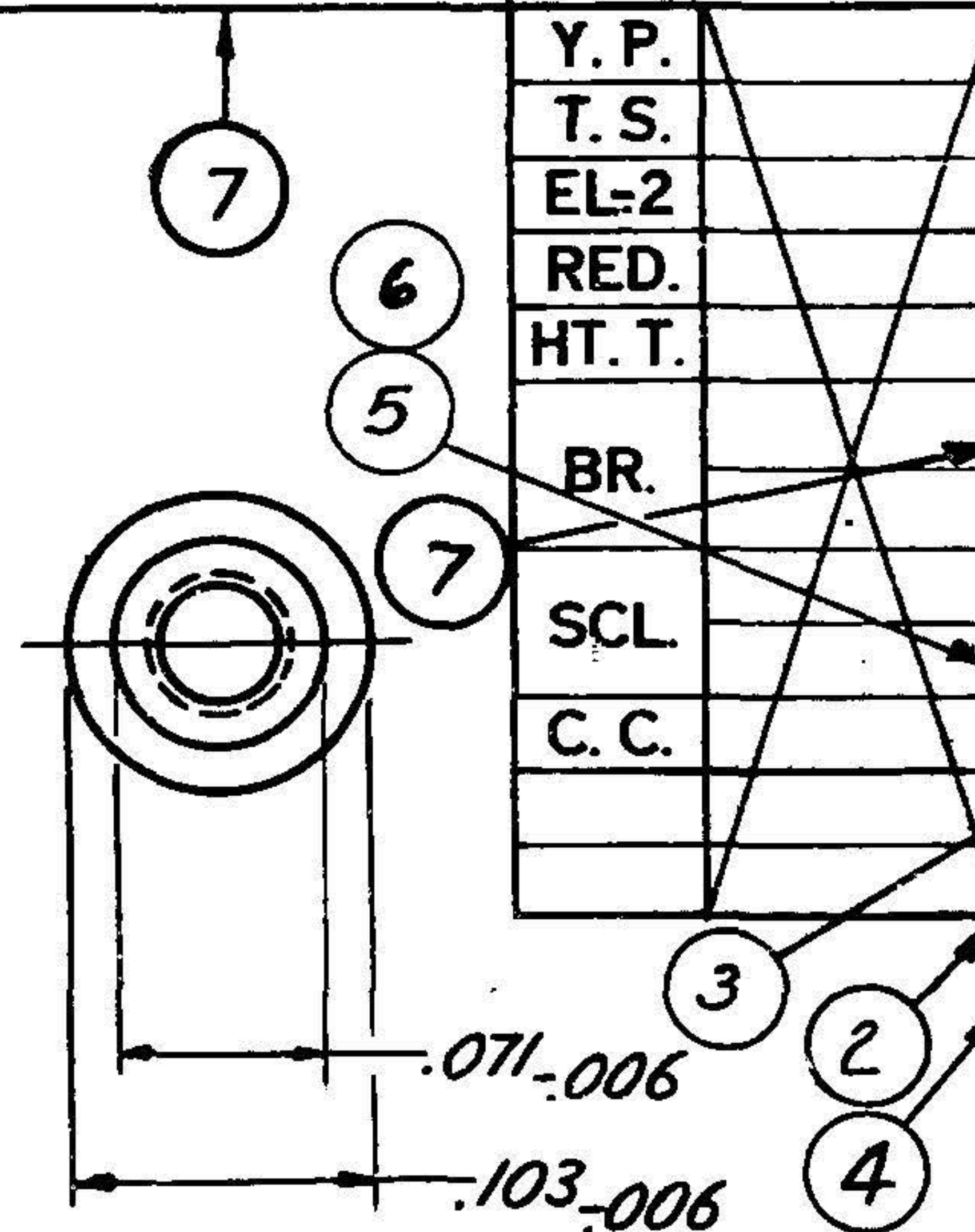
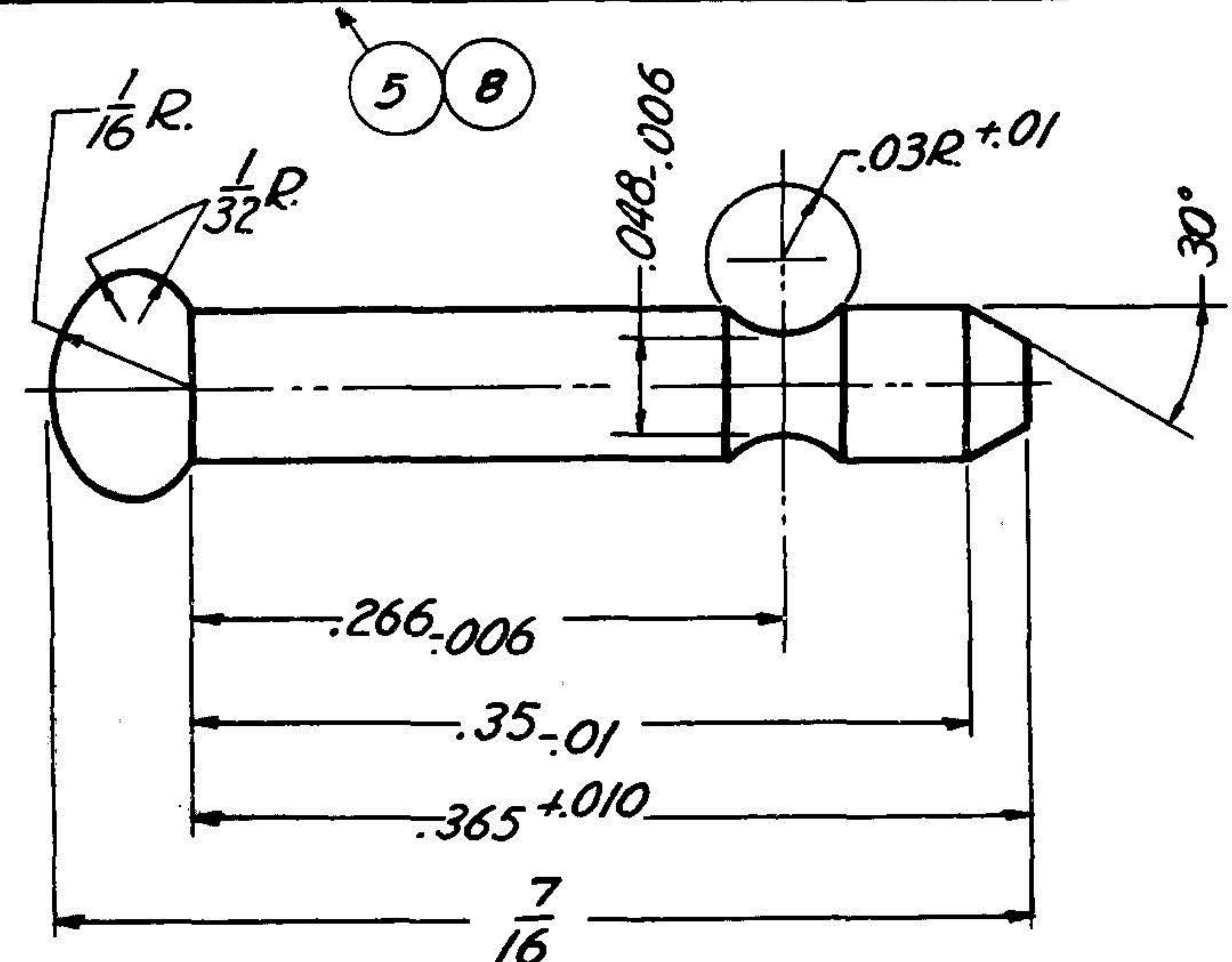
SUBMITTED:

*[Signature]*  
CAPT. ORD. DEPT. U.S.A.

APPROVED BY ORDER OF THE  
CHIEF OF ORDNANCE

*[Signature]*  
LT. COL. ORD. DEPT. U.S.A.

ORDNANCE DEPT. U.S.A.



PIN, RETAINING, CHANGE LEVER STOP SPRING

STEEL, FED SPEC QQ-S-633: FS 1095

FINISH ALL OVER 125/

TOLERANCE  $\pm .01$  ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SUPERSEDES OLD TRACING A22228

UNDER REVISION DATE OF JUNE 1, 1936

DWG B7266102 APPLIES

SCALE  $\frac{10}{1}$

A5022228

A22228

SUPERSEDES A22228



8

7

6

5

4

3

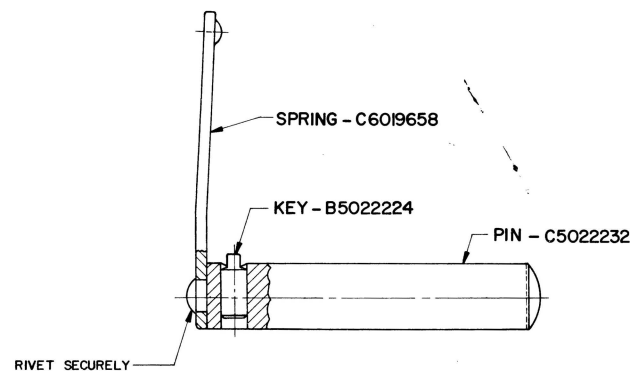
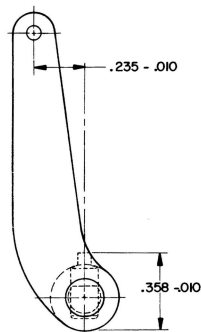
2

1

## NOTE:

FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OF MIL-STD-171.

REVISIONS			
MF	ZONE	LTR	DESCRIPTION
		A	REPLACES REV 13 W/ CHANGE
			SEE CD RIA - 14433
			4 OCT 67 <i>Shaw</i>



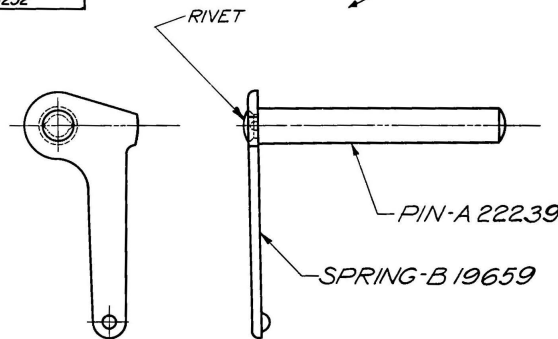
FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 5564074

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE: JUN 1936 OF DRAWING		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON	DECIMALS	TEXT	DESIGNER	E.L.J.	L.S.C.
TS		ANGLES	XXX	DESIGN	DESIGNER	E.L.J.	L.S.C.
EL 2		MATERIAL		DESIGN	DESIGNER	E.L.J.	L.S.C.
RA				DESIGN	DESIGNER	E.L.J.	L.S.C.
IN	F 7265703	BAR, CAL. 30		DESIGN	DESIGNER	E.L.J.	L.S.C.
IN		M1918A2		DESIGN	DESIGNER	E.L.J.	L.S.C.
NEXT ASSY.		USED ON	FINAL PROTECTIVE FINISH	SUBMITTED		DWD SIZE	
APPLICATION			SEE NOTE	APPROVED		CODE IDENT NO.	
				S. R. SPALDING		D 19204	
						5564074	
						SCALE 4/1	
						SHEET 1 OF 1	

HEAT TREATMENT & FINAL FINISH

PROT. FINSH: TYPE I SPEC MIL-C-16232

4 8



DO NOT INSCRIBE PART NO

6

PHYSICAL PROPERTIES

Y.P.	1	6-1-36
T.S.	2	4-15-38
EL-2	3	6-1-39
RED.	4	4-25-42
HT.T.	5	4-15-44
BR.	6	CONV. 3007 1-20-49 OIL-50
SCL.	7	9 JUNE 55
C.C.	8	19 AUG 55

MAY 1, 1929

REVISIONS

1	6-1-36
2	4-15-38
3	6-1-39
4	4-25-42
5	4-15-44
6	CONV. 3007 1-20-49 OIL-50
7	9 JUNE 55
8	19 AUG 55

DRG PERTAINS TO

51-13-30 B.A.R.-M19  
7285703-30 B.A.R.-M19 B.A.R.

SYMBOL

XYP 28

DFTSMAN	TRACER	L.D.A. DFTSMAN
E.L.J.	E.T.F.	U.S.C.
CHECKER	2-2-6	CHIEF DFTSMAN

SUBMITTED TO  
CAPT. ORD DEPT. U.S.A.

APPROVED BY ORDER OF THE  
CHIEF OF ORDNANCE:  
5-1-55  
LT. COL. ORD DEPT. U.S.A.

ORDNANCE DEPT. U.S.A.

PIN, RETAINING, TRIGGER GUARD, ASSEMBLY

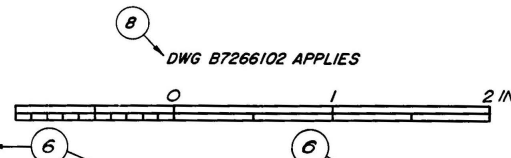
B 19680-4

6019680

LIST OF COMPONENTS

1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NUMBER REQUIRED
1	B 19680	PIN, RETAINING, TRIGGER GUARD, ASSEMBLY	(1)
2		COMPOSED OF:	
3	A 22239	1-PIN, RETAINING, TRIGGER GUARD	*
4	B 19659	1-SPRING, TRIGGER GUARD RETAINING PIN	*

\* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES  
SUPERSEDES OLD TRACING B 19680 UNDER REVISION DATE OF JUNE 1, 1936.



DWG B7266102 APPLIES

B 6019680

B 19680

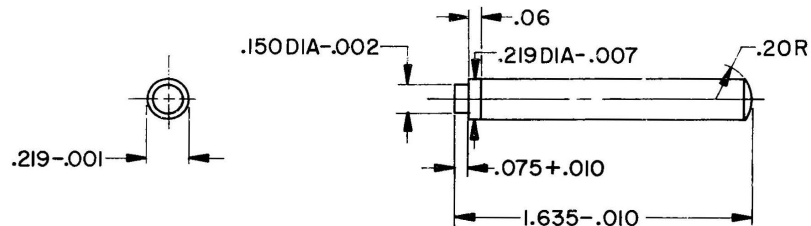
SUPERSEDES B 19680

B 6019680

NOTED: THIS DRAWING SHALL NOT BE USED OR REPRODUCED IN WHOLLY OR IN PART EXCEPT BY AUTHORITY OF THE UNITED STATES GOVERNMENT PROCUREMENT.

NOTES:

1. FINISH  $\sqrt{125}$  ALL OVER UNLESS OTHERWISE SPECIFIED.
2. ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL:  
STEEL, COMP 1095, SPEC QQ-S-777  
OR STEEL, GRADE A, CLASS W1-10,  
SPEC QQ-T-580.
4. HEAT TREATMENT:  
HEAT TO 1425°-1450°F IN SALT  
FOR 5 MINUTES. OIL QUENCH.  
TEMPER AT 700°F FOR 15  
MINUTES TO HARDNESS SPECIFIED.  
HEAT .25 INCH SHOULDER END IN LEAD  
AT 1200°F. HEAT TREATMENT  
METHOD IS FOR GUIDANCE ONLY,  
EXCEPT TEMPERING TIME SHALL  
NOT BE REDUCED BELOW THAT  
SPECIFIED.



REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	REDRAWN WITH CHANGE SEE EO HRD 92117	14 JUL 69

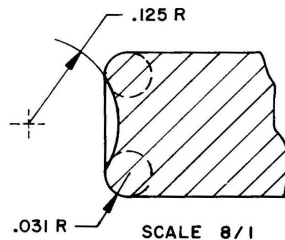
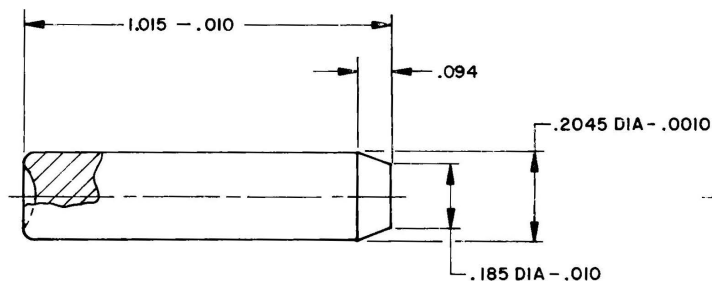
PART NO. 5022239

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 MAY 1929		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON DECIMALS .XX ±.01		DRAFTSMAN M.C. Munch	CHECKER M.C. Munch	PIN, RETAINING, TRIGGER GUARD	
TS		ANGLES ± XXX ±		TRACER M.C. Munch	CHECKER M.C. Munch		
EL 2		MATERIAL SEE NOTE 3		ENGINEER R.D. Hammer	ENGINEER R.D. Hammer		
RA	B6019680	30 BAR		SUBMITTED Theodore L. Brannen Jr.		DWG SIZE B	CODE IDENT NO. 19204
BH		MI918A2		APPROVED Theodore L. Brannen Jr.		5022239	
RH	C45-55	APPLICATION		FINAL PROTECTIVE FINISH		SCALE 2/1	UNIT WT
						SHEET	OF

SWRI FORM 40B, 1 MAR 67

NOTES:

1. FINISH ALL OVER  $\sqrt{\text{V}}$ .
2. ALL EDGES SHALL BE BROKEN .003 +.012 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL:  
STEEL, COMP 1095, SPEC QQ-S-634.
4. HEAT TREATMENT:  
HEAT AT 1425° TO 1475° F. OIL QUENCH. TEMPER 30 MINUTES TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE ONLY EXCEPT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171



SCALE 8/1

REVISIONS

LTR	DESCRIPTION	DATE	APPROVED
A	REDRAWN & REVISED W/CHANGE SEE EO RIA-14488	25 JAN 68	<i>Handling</i>

PART NO. 5022237

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 MAY 1929		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		F6535469	.30 B.A.R	TOLERANCES ON FRACTIONS ±	DECIMALS ± .015	DRAFTSMAN E. L. J.	CHECKER L. S. C.
TS			M1918A2	FRACTIONS ±	ANGLES ±	TRACER E. L. J.	CHECKER E. L. J.
EL 2		SEE ENGINEERING RECORDS		MATERIAL SEE NOTE 3		ENGINEER T. J. C.	ENGINEER E. W. S.
RA		NEXT ASSY	USED ON	HEAT TREATMENT SEE NOTE 4		SUBMITTED Philip C. Nebala	
BH		APPLICATION		FINAL PROTECTIVE FINISH SEE NOTE 5		APPROVED E. J. Henry	
RH	C 45-55	APPLY PART NO.				DWG SIZE B	CODE IDENT NO. 19204
						SCALE 4/1	UNIT WT
						SHEET 1 OF 1	

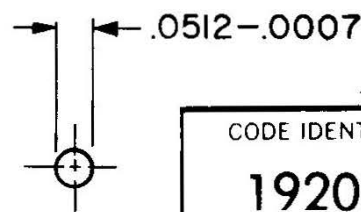
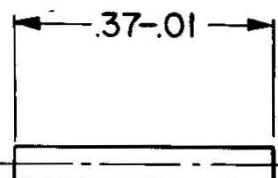
PIN, SEAR

5022237

MECHANICAL PROPERTIES		APPLY PART NO.		REVISIONS			
YP		APPLICATION		LTR	DESCRIPTION	DATE	APPROVED
TS		NEXT ASSY	USED ON				
EL2				C	REDRAWN WITH CHANGE SEE EO SA29355	17 FEB 67	<i>[Signature]</i>
RA				D	(1-2) SEE EO RIA-14469	3 NOV 67	<i>[Signature]</i>
BH		D7267936	SEE	E	(3) SEE ERR HQR 30691	18 APR 73	<i>[Signature]</i>
		D5564208	NOTE	F	(3) SEE ERR HQR 50606	4 APR 75	<i>[Signature]</i>
RH			3	G	(2) SEE ERR HQR 50655	1 OCT 75	<i>[Signature]</i>
		C5545964		H	NORW8S3010 7903-16	79-11-20	

# NOTES:

- FINISH <sup>125</sup>✓ ALL OVER.
- BREAK EDGES .003+.005 UNLESS OTHERWISE SPECIFIED.
- APPLICATION: USED ON  
MG CAL.50; M2 HB FLEX, FXD;  
MG CAL.30; MI9A6, MI9A4, FLEX,  
MG CAL.30 AR; MI918A2.
- MATERIAL: STEEL, ASTM A108;  
1035 THRU 1045 OR SPEC QQ-T-580;  
CLASS WI-10. GRADE C.
- MIL-W-13855 APPLIES.



CODE IDENT NO.  
**19200**

- FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2 OF  
MIL-STD-171.

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND  
DOVER, NEW JERSEY 07801

(USED WITH KNOB-5013610)

PART NO. **5013166**

DEPT OF THE ARMY

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE OF DRAWING <b>1 MAY 29</b>
TOLERANCES ON FRACTIONS DECIMALS ANGLES + - + -	DRAFTSMAN <i>RJE</i> CHECKER <i>CK</i> TRACER <i>RJE</i> CHECKER <i>CK</i> ENGR. <i>[Signature]</i>
MATERIAL <b>SEE NOTE 4</b>	SUBMITTED <i>[Signature]</i>
HEAT TREATMENT _____	APPROVED <i>[Signature]</i>
FINAL PROTECTIVE FINISH <b>SEE NOTE 6</b>	

<del>ROCK ISLAND ARSENAL</del> <del>ROCK ISLAND, ILL 61201</del>	
<b>PIN, STRAIGHT, HEADLESS</b>	
DWG SIZE <b>A</b>	CODE IDENT NO <del>19200</del> <b>5013166</b>
SCALE <b>4/1</b>	UNIT WT SHEET   OF



4

3

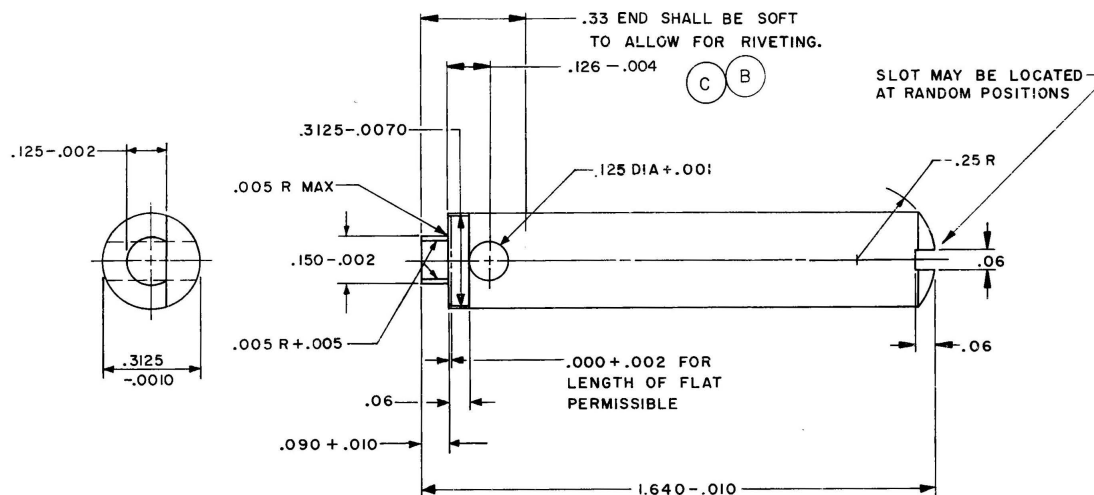
2

1

## NOTES:

1. FINISH  $\frac{125}{\sqrt{}}$ .
2. MATERIAL: STEEL, COMP 1095,  
SPEC QQ-S-631  
OR  
STEEL, TOOL, CLASS W1-09,  
SPEC QQ-T-580.
3. HEAT TREATMENT: HEAT AT  
1425° TO 1450°F. OIL QUENCH.  
TEMPER 1 HOUR AT HEAT TO  
HARDNESS SPECIFIED. LOCALLY  
TEMPER SHOULDER END AT  
1250°F FOR DISTANCE OF .33.  
HEAT TREATMENT METHOD IS  
FOR GUIDANCE ONLY EXCEPT  
TEMPERING TIME SHALL NOT  
BE REDUCED BELOW THAT  
SPECIFIED.

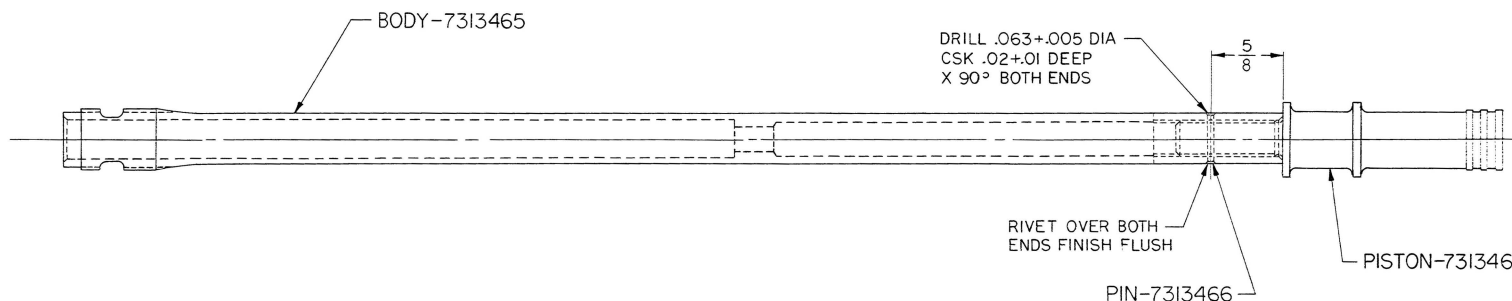
REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
4		A	REPLACES REV 15 W/CHANGE	
			SEE EO RIA-14433	4 OCT 67
10		B	SEE EO 82053	7 MAR 68
		C	SEE EO 82098	10 APR 68



MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 MAY, 1929		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON DECIMALS XX ± .02		DRAFTSMAN MEB	CHECKER MEB	PIN	
TS		ANGLES ± XXX ±		TRACKS P. H. M. P. P. P.	CHECKER P. H. M. P. P. P.		
EL 2		MATERIAL	SEE NOTE 2	ENGINEER LSC	ENGINEER EJA		
RA		HEAT TREATMENT	SEE NOTE 3	SUBMITTED E.M. HOPKINS			
BH		D 5564074 BAR, CAL .30		APPROVED R. WHITTAKER		DWG SIZE C	CODE IDENT NO. 19204
RH	C 45-50	MI918A2				5022232	
		NEXT ASSY. USED ON	FINAL PROTECTIVE FINISH			SCALE 4/1	UNIT WT
		APPLICATION				SHEET 1	OF 1

NOTES:  
 1. PISTON SHALL BE SCREWED TIGHT  
 AGAINST BODY.  
 2. MIL-W-13855 APPLIES.

REVISIONS				
MP	ZONE	LTR	DESCRIPTION	DATE
		8	REPLACES REVISION A WITH CHANGE. SEE NDR 75E0014-0004	21 SEP 75



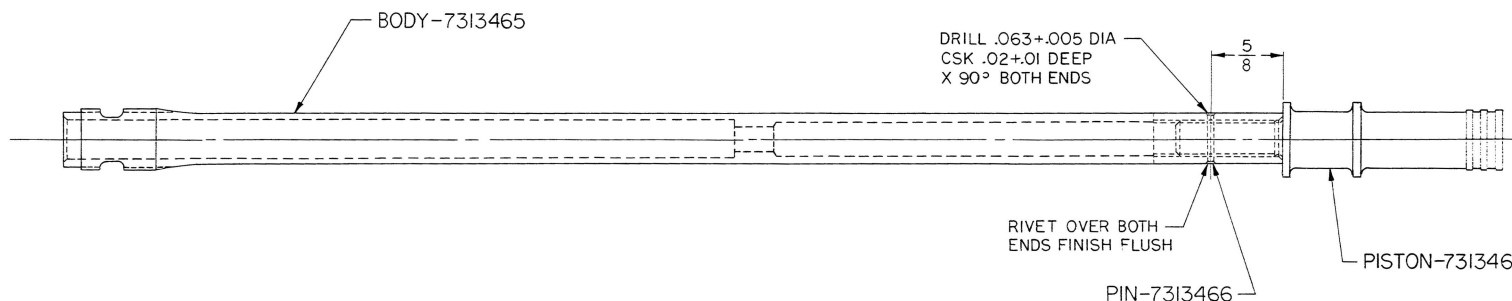
SEE EPL-7313467

PART NO. 7313467

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 24 OCT 45		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON FRACTIONS 1/64 .XX ±		DESIGNED BY J. D. B. B. B.		PISTON ASSEMBLY	
TS		ANGLES ± 2°		CHECKED BY J. D. B. B. B.			
RA		MATERIAL		ENGINEER J. D. B. B. B.			
EL 2				SUBMITTER J. D. B. B. B.			
BH	F7313513	RIFLE CAL 30	HEAT TREATMENT	APPROVED J. D. B. B. B.		DWG SIZE   CODE IDENT NO.   D 19204 7313467	
RH		NEXT ASSY.	USED ON	FINAL PROTECTIVE FINISH		SCALE 2/1   UNIT WT     SHEET 1 OF 1	
APPLICATION							

NOTES:  
 1. PISTON SHALL BE SCREWED TIGHT  
 AGAINST BODY.  
 2. MIL-W-13855 APPLIES.

REVISIONS				
MP	ZONE	LTR	DESCRIPTION	DATE
		8	REPLACES REVISION A WITH CHANGE. SEE NDR 75E0014-0004	21 SEP 75



SEE EPL-7313467

PART NO. 7313467

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 24 OCT 45	DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201
YP		TOLERANCES ON FRACTIONS 1/64 .XX ±		DESIGNED BY J. D. B. B. B.	PISTON ASSEMBLY
TS		ANGLES ± 2°		CHECKED BY J. D. B. B. B.	
RA		MATERIAL		ENGINEER J. D. B. B. B.	
EL 2				SUBMITTED J. D. B. B. B.	
BH	F7313513	RIFLE CAL 30	HEAT TREATMENT	APPROVED J. D. B. B. B.	DWG SIZE   CODE IDENT NO.   D   19204   7313467
RH		M1918A2 (BAR)	FINAL PROTECTIVE FINISH	SCALE 2/1	UNIT WT.   SHEET 1 OF 1
APPLICATION					

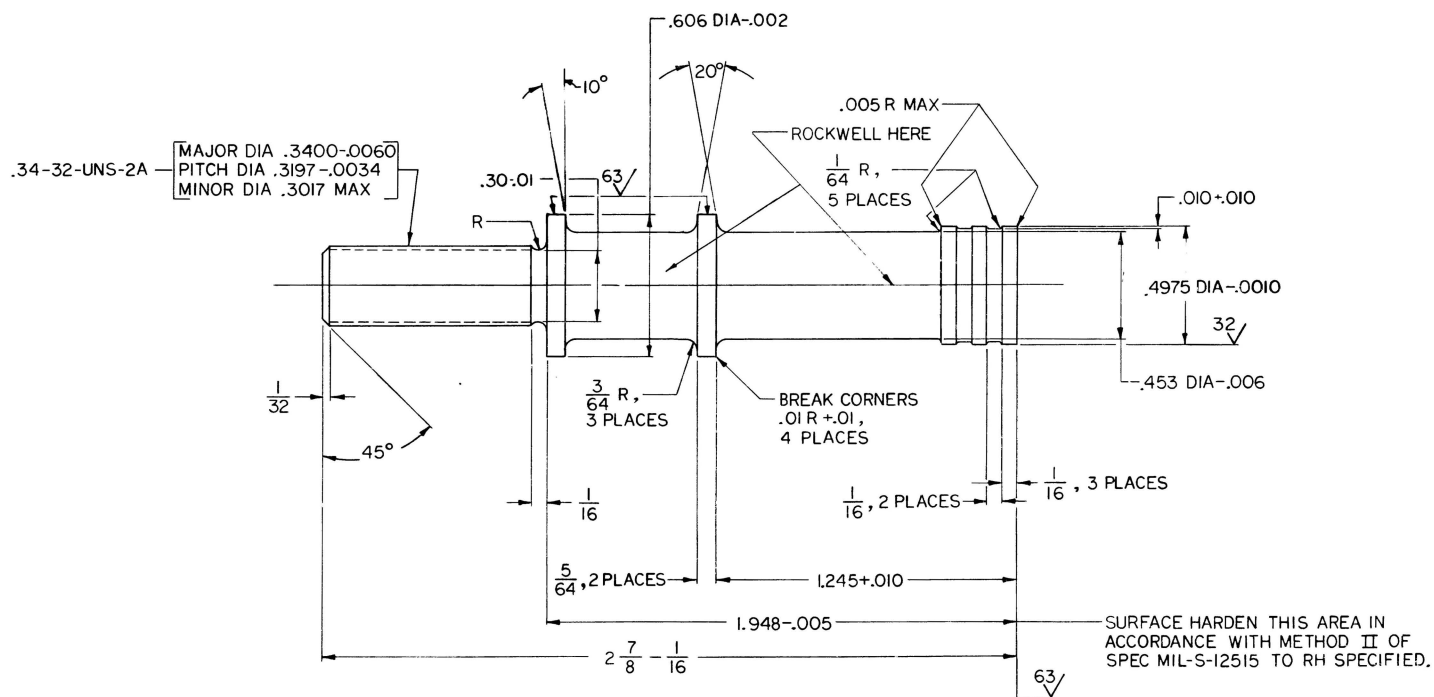
# NOTES:

1. STEEL, CORROSION RESISTING, CLASS 420  
SPEC QQ-S-763.

2. FINISH  $125\sqrt{\text{ }}$  EXCEPT AS NOTED.

3. MIL-W-13855 APPLIES.

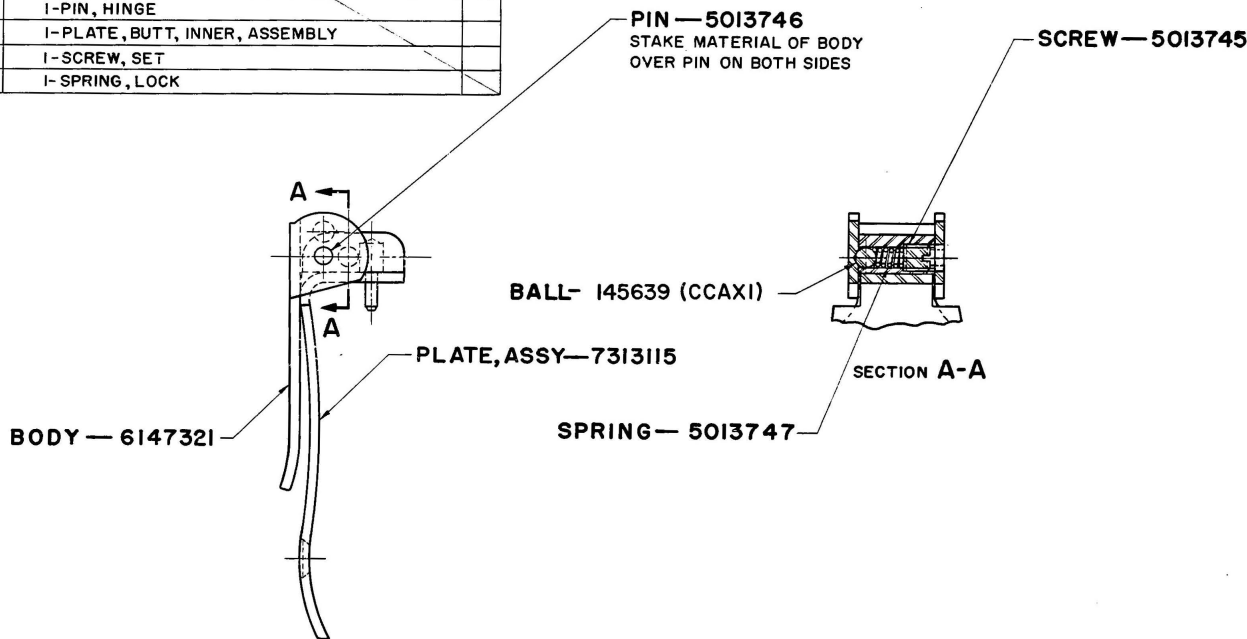
REVISIONS				
MF	ZONE	DESCRIPTION	DATE	APPROVED
	B	REPLACES REV A WITH CHANGE SEE NCR 75E0014-0001	21 SEP 75	



MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 24 OCT 45		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON FRACTIONS 1/64 XX .01		CHECKED <i>Robert R. Reed</i>		PISTON, GAS	
TS		ANGLES 1/2°		DESIGNED <i>Robert R. Reed</i>			
EL 2		MATERIAL		FORGEMAN <i>Robert R. Reed</i>			
RA		SEE NOTE I		SUBMITTED <i>Robert R. Reed</i>			
BH	D7313467	RIFLE, CAL. 30	HEAT TREATMENT	APPROVED <i>Donald A. Battlemont</i>		DWG SIZE CODE IDENT NO	
RH	A70-74	M1918A2 (BAR)	FINAL PROTECTIVE FINISH	APPROVED <i>R. D. Cole</i>		D 19204 7313464	
APPLICATION				SCALE 4/1		UNIT WT	

# LIST OF COMPONENTS

1	2	3	4
LINE NUMBER	DRAWING NUMBER	NAME OF COMPONENT	NUMBER REQUIRED
1	C7313114	PLATE, BUTT, HINGED, ASSEMBLY	1
2		COMPOSED OF:-	
3	CCAXI(145639)	I-BALL, STEEL, $\frac{1}{4}$ , GRADE 3	
4	C647321	I-BODY, BUTT PLATE, OUTER	
5	A5013746	I-PIN, HINGE	
6	C7313115	I-PLATE, BUTT, INNER, ASSEMBLY	
7	A5013745	I-SCREW, SET	
8	B5013747	I-SPRING, LOCK	



U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND  
DOVER, NEW JERSEY 07801

CODE IDENT NO.  
19200

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7313114  
DWG B7266102 APPLIES ORD PART NO. 7313114

SYB	DESCRIPTION	DATE	APPROVAL
B	NOR WBS2022/79-03-26	790401	SAT 11
A	REDRAWN AND REVISED	1 MAY 58	Henry
3	WAS "B" SIZE	9 JUN 55	

<b>PHYSICAL PROPERTIES</b> F 7265703 .30 BAR M1918 A2		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ANGLES FRACTIONS MATERIAL HEAT TREATMENT FINAL PROTECTIVE FINISH		ORIGINAL DATE 1 MAY 45 OF DRAWING DRAFTSMAN M.E.B. CHECKER J.S. TRACER M.M. CHECKER J.S. ENGINEER S.L. ENGINEER Henry SUBMITTER APPROVED BY ORDER OF THE CHIEF OF ORDNANCE J.S. Lynch		PLATE, BUTT, HINGED, ASSEMBLY SCALE 1/1 UNIT WT .59		SPRINGFIELD ARMOY ORDNANCE CORPS DEPT OF THE ARMY SPRINGFIELD, MASS. DWG NO. 7313114 SHEET 1 OF 1	
APPLICATION DO NOT APPLY PART NO. AS SPECIFIED		NEXT ASSY USED ON USED ON		APPROVED BY ORDER OF THE CHIEF OF ORDNANCE J.S. Lynch		SPRINGFIELD ARMOY ORDNANCE CORPS DEPT OF THE ARMY SPRINGFIELD, MASS. DWG NO. 7313114 SHEET 1 OF 1		SPRINGFIELD ARMOY ORDNANCE CORPS DEPT OF THE ARMY SPRINGFIELD, MASS. DWG NO. 7313114 SHEET 1 OF 1	

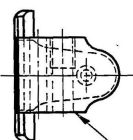
C 7313114

B

A

NOTES:

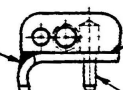
1. WELD IN ACCORDANCE WITH MIL-STD-1261, CLASS I, PROCESS WITH FILLER ROD MIL-R-5632, CLASS I.
2. HEAT TREATMENT :  
CARBURIZE IN LIQUID SALT AT 1550° TO 1600° F FROM .004 TO .008 CASE DEPTH. OIL QUENCH. TEMPER AT 350° F MIN FOR 30 MINUTES. HEAT TREATMENT METHOD IS FOR GUIDANCE ONLY EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBONITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF CONTRACTING OFFICER.
3. MIL-W-13855 APPLIES.



LUG—7313113

(B1) SEE NOTE 1

FINISH FLUSH



FINISH FLUSH

(B3) SEE NOTE 1

PIN—7313116

BODY—5613687

CODE IDENT NO. 19204

PART NO. 7313115

SEE PL-7313115

PHYSICAL PROPERTIES		C 7313114		RIFLE: M1918A2 BAR		TOLERANCES ON ANGLES DECIMALS FRACTIONS		ORIGINAL DATE OF DRAWING 1 MAY 45		DRAFTSMAN MEB		CHECKER		ROCK ISLAND, ARSENAL	
TP														DEPT OF THE ARMY	
TS														ROCK ISLAND, ILL. 61201	
EL 2														DWG SIZE	
RA														7313115	
BH														C	
		NEXT ASSY		USED ON		HEAT TREATMENT SEE NOTE 2		SUBMITTED		APPROVED BY ORDER OF THE CHIEF OF ARSENAL		SCALE 1/1		UNIT WT .39	
FILEHARD		DO NOT		APPLY PART NO.		FINAL PROTECTIVE FINISH FINISH NO. 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.		VA Lankhoren		ORD CORPS				SHEET 1 OF 1	
		98-		-AS SPECIFIED-											

SYN	DESCRIPTION	DATE	APPROVAL
C	(2) SEE ERR HQR 50627	25 MAR 75	R. M. Hite
B	(1-3) SEE EO RIA-14535	21 DEC 67	G. H. Hite
A	REDRAWN AND REVISED	1 MAY 58	R. Henry
2		19 AUG 55	

PLATE,  
BUTT, INNER,  
ASSEMBLY

ROCK ISLAND, ARSENAL  
DEPT OF THE ARMY  
ROCK ISLAND, ILL. 61201

DWG SIZE  
C  
SHEET 1 OF 1

C C 7313115

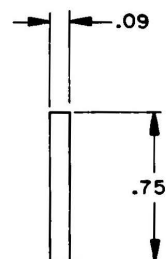
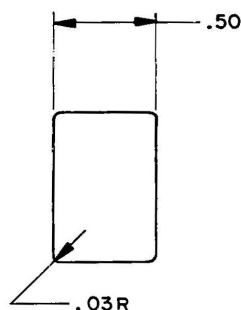
B

A

NOTES:  
1. FINISH  $\sqrt{125}$ .

2. MATERIAL:  
STEEL, COND CR, COMP 1009,  
SPEC QQ-S-698.

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	REDRAWN & REVISED W/ CHANGE SEE EO RIA-14533	18, DEC 1967	<i>R. Ash</i>



PART NO. 7266133

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 15 OCT 51		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON	DECIMALS .XX ± .01	DRAFTSMAN	R.H.S	CHECKER	D.H
TS		ANGLES ±	.XXX ±	TRACER	<i>Raymond D. Jones</i>	CHECKER	<i>Raymond D. Jones</i>
EL 2		MATERIAL	SEE NOTE 2	ENGINEER		ENGINEER	R.W.M
RA	C7266132	HEAT TREATMENT	AT ASSEMBLY	SUBMITTED			
BH	M18A2	FINAL PROTECTIVE FINISH		APPROVED			
RH		APPLICATION		<div> <div> </div> <div> </div> </div>			
		NEXT ASSY.	USED ON	DWG SIZE	B	CODE IDENT NO.	19204
				SCALE	2/1	UNIT WT	
				SHEET	1	OF	1
				PLATE			
				7266133			

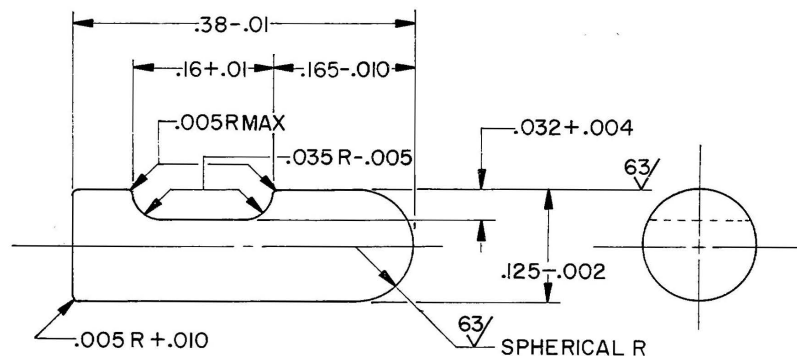




# NOTES:

1. FINISH  $\sqrt{125}$  ALL OVER UNLESS OTHERWISE SPECIFIED.
2. ALL EDGES SHALL BE BROKEN  $.005 \pm .010$  UNLESS OTHERWISE SPECIFIED.
3. MATERIAL:  
STEEL, CMPSN 1085, SPEC ASTM A684 OR STEEL, GRADE A, CLASS W1-10, SPEC QQ-T-580.
4. HEAT TREATMENT:  
HEAT AT 1475°-1500°F. OIL QUENCH. TEMPER 20 MIN TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE ONLY, EXCEPT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OF MIL-STD-171.
6. MIL-W-13855 APPLIES. (C)

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		B	REDRAWN WITH CHANGE		R.W.
			SEE EO HRD 92117	14 JUL 69	R. W. Johnson
		C	SEE ERR HQR 50616	26 FEB 75	R. W. Johnson



PART NO. 7267858

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 27 MAY 55	DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON DECIMALS .XX ±		DRAFTSMAN M.C. Munch	CHECKER A.M. Ludell	PLUNGER, GAS REGULATOR
TS		ANGLES ± .XXX ±		TRACER M.C. Munch	CHECKER A.M. Ludell	
EL 2	C7267816	MATERIAL SEE NOTE 3		ENGINEER R. W. Johnson	ENGINEER A.M. Ludell	
RA		HEAT TREATMENT SEE NOTE 4		SUBMITTED		
BH		FINAL PROTECTIVE FINISH SEE NOTE 5		APPROVED R. W. Johnson		
RH	C40-45	NEXT ASSY. USED ON APPLICATION		DWG SIZE CODE IDENT NO. B 19204 7267858		
SCALE 10/1				UNIT WT		SHEET OF

CWED1 FROM APP 1 MAP 47

NOTICE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED IN WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

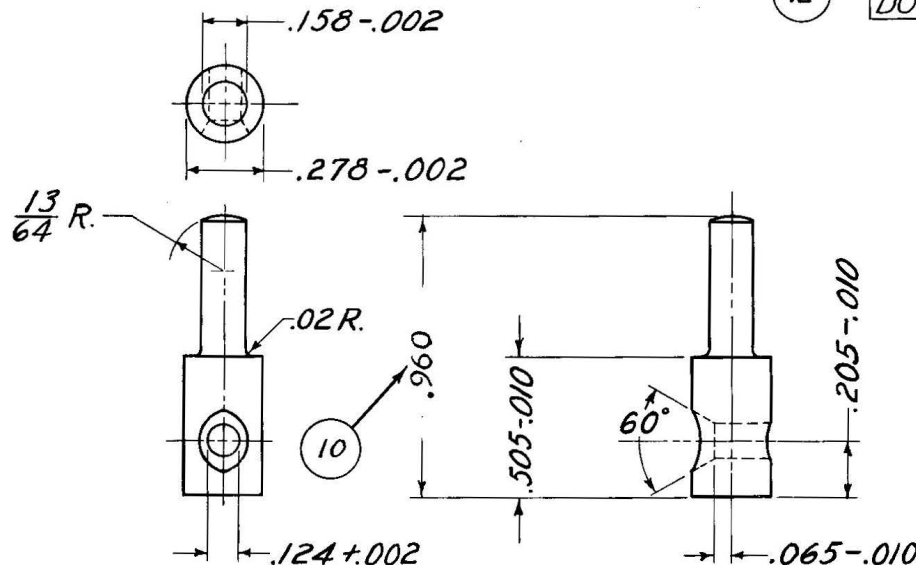
A 22241

MAY 1, 1929

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				REVISIONS	
HEAT TO 1425°F.-1450°F. IN SALT 5 MINUTES. QUENCH IN OIL. TEMPER 1/2 HOUR AT HEAT TO OBTAIN ROCKWELL SPECIFIED. PROT. FIN. TYPE I SPEC MIL-C-16232		Y.P.		RED.		8	7-7-44
		T.S.		BR.	ROCK.	9 <sup>2</sup>	CONVERSION 1-28-49
		EL.2				10	4-28-53
						11	9 JUNE 55
						12 <sup>3</sup>	19 AUG 55

DO NOT INSCRIBE PART NO.

12



9

11

DR'G. PERTAINS TO

51-13 .30 B.A.R.-M18  
F7265703 .30 B.A.R. M1918 A2

PLUNGER, OPERATING HANDLE  
STEEL, FED SPEC QQ-S-633 FS 1095  
FINISH ALL OVER 125

5022241

A22241-6

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.  
BASED ON OLD TRACING A22241  
UNREVISION DATE OF JULY 7, 1944.

DWG B7266102 APPLIES

12

SCALE 2/1

SPRINGFIELD ARMOY  
A5022241

A22241

9

DFTSMAN TRACER L'DG. DFTSMAN  
L.L.B. P.L.B. L.L.B.  
CHECKER S.A. O.O. S.A. O.O.  
SUBMITTED:

HO ORD. ENG., ORD. DEPT.

APPROVED BY ORDER OF THE  
CHIEF OF ORDNANCE:  
LT. COL., ORD. DEPT.

ORDNANCE DEPT., U. S. A.

SUPERSEDES A22241

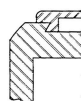
A5022241



# HEAT TREATMENT & FINAL FINISH

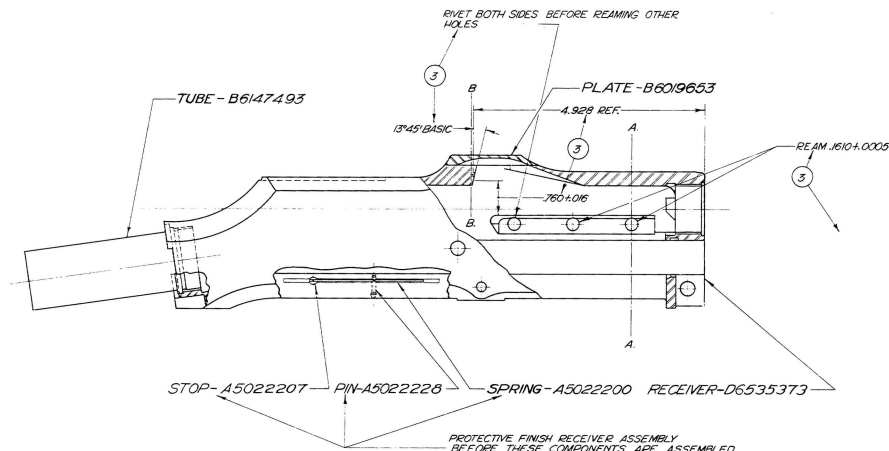
PROT FIN. TYPE I SPEC. MIL-C-16232  
EXCEPT CHANGE LEVER STOP SPRING ASSY

5

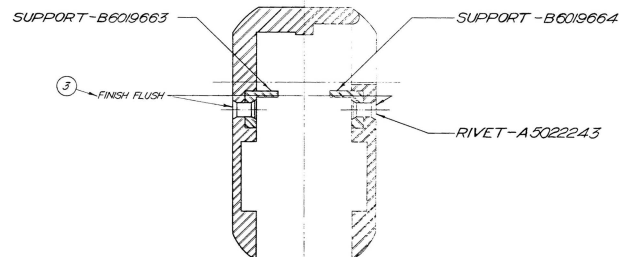


SECTION B-B

SCALE  $\frac{F}{1}$



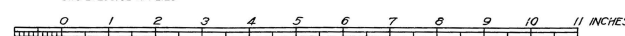
PROTECTIVE FINISH RECEIVER ASSEMBLY  
BEFORE THESE COMPONENTS ARE ASSEMBLED



SECTION A-A

SCALE  $\frac{F}{1}$

DWG B7266102 APPLIES



RECEIVER ASSEMBLY D6535472 6535472  
MANUFACTURING ASSEMBLY

NOTICE: THIS DRAWING SHALL NOT BE USED OR  
REPRODUCED EITHER WHOLLY OR IN PART EXCEPT  
WHEN AUTHORIZED IN CONNECTION WITH  
UNITED STATES GOVERNMENT PROCUREMENT.

LIST OF COMPONENTS			
1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NO REQUIRED PER UNIT ASM
1	D6535472	RECEIVER, ASSEMBLY	(1)
2		COMPOSED OF:-	
3	A5022228	1-PIN, RETAINING, CHANGE LEVER STOP SPRING	
4	B6019653	1-PLATE, TOP	
5	D6535373	1-RECEIVER	*
6	A5022243	6-RIVET, BOLT SUPPORT	
7			
8	B6019697	1-SPRING, CHANGE LEVER STOP, ASSEMBLY	
9	B6019663	1-SUPPORT, BOLT, LEFT	
10	B6019664	1-SUPPORT, BOLT, RIGHT	
11	B6147493	1-TUBE, BUFFER	

\* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.

TOLERANCES UNLESS OTHERWISE SPECIFIED.  
DECIMALS  $\pm .01$   
FRACTIONS  $\pm \frac{1}{64}$   
ANGULAR  $\pm 1^\circ$

PHYSICAL PROPERTIES	
Y.P.T.	
T.S.	
EL-2	
RED.	
HT.T.	
BR.	
SCL.	
C.C.	

D6535472

JUNE 5, 1940		CLASS	DIVISION	DRAWING	FILE
REVISIONS					
1	15-28-40				
2	2-28-40				
3	8-14-40				
4	9-JUNE-50				
5	19-AUG-55				
SYMBOL					
DO NOT INSCRIBE PART NO.					
DFTSMAN TRACER L'G. DFTSMAN					
H&O H&O					
CHECKER CHECKER CHIEF DFTSMAN					
H&O H&O					
SUBMITTED					
MAJOR ORG. DEPT. U.S.A.					
EXAMINED					
LT. COL. ORG. DEPT. U.S.A.					
APPROVED BY ORDER OF THE					
CHIEF OF ORDNANCE					
ORDNANCE OFFICE, WAR DEPT.					

SUPERSEDES D35472

1

# LIST OF COMPONENTS

1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENTS	NUMBER REQ.
1	C7267816	REGULATOR, GAS CYLINDER, ASSEMBLY	(1)
2		COMPOSED OF:	
3	B7266089	1- PIN, LOCK, PLUNGER	
4	B7267858	1- PLUNGER, GAS REGULATOR	
5	D7267817	1- REGULATOR, GAS CYLINDER	
6	B7266090	1- SPRING, PLUNGER	

## NOTES:

1. MIL-W-13855 APPLIES.

REGULATOR — 7267817

PLUNGER — 7267858

SPRING — 7266090

PIN — 7266089

STAKE METAL OF REGULATOR  
SECURELY OVER PIN

C7267816

CODE IDENT NO. 19204  
PART NO. 7267816

SEE PL-7267816

<b>PHYSICAL PROPERTIES</b> TP TS EL 2 RA BH RH		C7267819 30BAR, M1918A2 NEXT ASSY USED ON APPLICATION DO NOT APPLY PART NO. AS-SPECIFIED	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ANGLES FRACTIONS MATERIAL HEAT TREATMENT FINAL PROTECTIVE FINISH	ORIGINAL DATE OF DRAWING 27 MAY 1955 DRAFTSMAN <i>R.H.H.</i> CHECKER <i>AP</i> TRACER <i>R.H.H.</i> CHECKER <i>AP</i> ENGINEER <i>PHILIP</i> ENGINEER <i>AP</i> SUBMITTED <i>H. J. Lynch</i> LT. COL. ORG. CORPS APPROVED BY ORDER OF THE CHIEF OF ORDNANCE <i>W. J. Lynch</i> LT. COL. ORG. CORPS	<b>REGULATOR, GAS CYLINDER, ASSEMBLY</b> DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 61201 DWG SIZE C 7267816 SCALE 4/1 UNIT WT .08 SHEET 1 of 1
--	--	---	--	---	---

SYN	DESCRIPTION	DATE	APPROVAL
B	(3) SEE ERR HQR 50616	26 FEB 75	<i>AP</i>
A	REF EO NO. SA 24549	15 DEC 68	<i>AP</i>
	SUPERSEDES B 7266106		
	W/C 27 MAY 55		

THIS DRAWING SHALL NOT BE USED FOR REPRODUCTION OR IN ANY MANNER WITHOUT THE AUTHORIZATION OF THE ARMY. IT IS THE PROPERTY OF THE ARMY AND IS LOANED TO YOU. IT IS TO BE RETURNED TO THE ARMY WHEN NO LONGER NEEDED.

C 7267816

B

A

D  
D 7267817

C

B

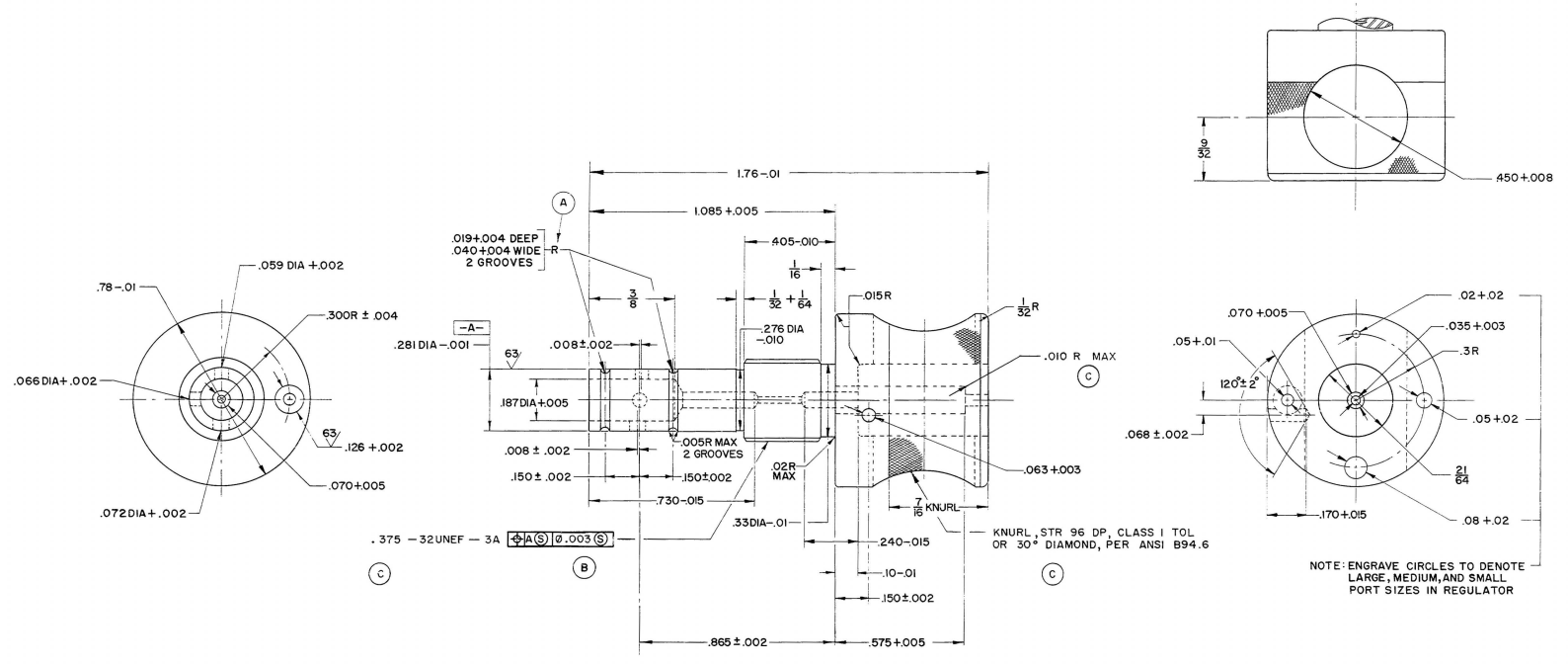
A

D

C

B

A



MIL-W-13855 APPLIES.

CORNERS AND EDGES SHALL BE .005 R + .010 UNLESS OTHERWISE SPECIFIED.

125/ ALL OVER EXCEPT AS NOTED

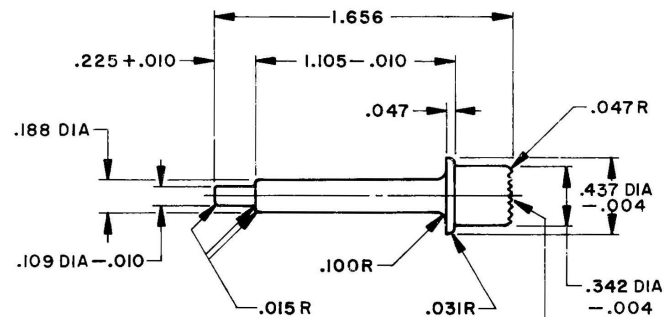
HEAT TREATMENT: HEAT AT 1800°-1850°F. QUENCH IN OIL. TEMPER 30 MINUTES AT HEAT TO RH SPECIFIED.

MATERIAL: STEEL, CORROSION RESISTING, FED SPEC QQ-S-763, CLASS 420, CONDITION A.

PHYSICAL PROPERTIES		TOLERANCES ON DIMENSIONS		MATERIAL		HEAT TREATMENT		FINISH		REVISIONS		DEPT OF THE ARMY	
ITEM	DESCRIPTION	VALUE	UNIT	VALUE	UNIT	VALUE	UNIT	VALUE	UNIT	NO.	DATE	DESCRIPTION	DATE
1	CT267816	30BAR, M1918A2		2.01	INCHES	1/16		27 MAY 1955		1	27 MAY 1955	REGULATOR, GAS CYLINDER	27 MAY 1955
2										2			
3										3			
4										4			
5										5			
6										6			
7										7			
8										8			
9										9			
10										10			
11										11			
12										12			
13										13			
14										14			
15										15			
16										16			
17										17			
18										18			
19										19			
20										20			
21										21			
22										22			
23										23			
24										24			
25										25			
26										26			
27										27			
28										28			
29										29			
30										30			
31										31			
32										32			
33										33			
34										34			
35										35			
36										36			
37										37			
38										38			
39										39			
40										40			
41										41			
42										42			
43										43			
44										44			
45										45			
46										46			
47										47			
48										48			
49										49			
50										50			

NOTES:

1. FINISH ALL OVER  $125^\circ$ .
2. MATERIAL:  
STEEL, COMP III7, SPEC QQ-S-637.
3. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2 OF  
MIL-STD-171



128 DP KNURL, 45° DIAMOND,  
CLASS I TOL, IN ACCORDANCE  
WITH ASA B94.6-1966

REVISIONS

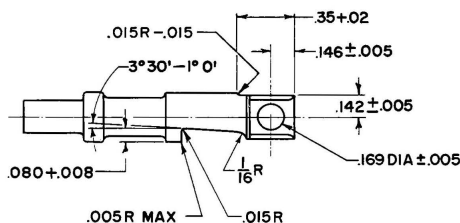
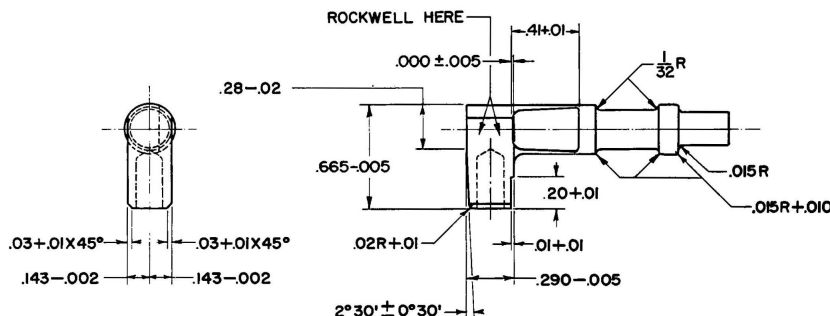
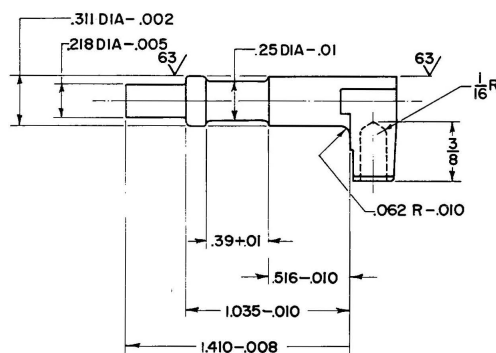
LTR	DESCRIPTION	DATE	APPROVED
A	REDRAWN & REVISED W/CHANGE SEE EO RIA-14488	25 JAN 68	<i>Karolus</i>

PART NO. 5022242

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 MAY 1929		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		F6535469	.30 B.A.R.	TOLERANCES ON DECIMALS ± .015	DRAFTSMAN D.E.P.	CHECKER M.E.B.	RELEASE, MAGAZINE
TS			M1918A2	FRACTIONS ± ANGLES ±	TRACER <i>T. Ring</i>	CHECKER <i>E.H.</i>	
EL 2		SEE ENGINEERING RECORDS		MATERIAL SEE NOTE 2	ENGINEER L.S.C.	ENGINEER E.J.A.	
RA		NEXT ASSY	USED ON	HEAT TREATMENT	SUBMITTED <i>Philip E. Hebbel</i>		
BH		APPLICATION		FINAL PROTECTIVE FINISH SEE NOTE 3	APPROVED <i>R. S. Henry</i>		DWG SIZE B
RH		APPLY PART NO.					CODE IDENT NO. 19204
							5022242
					SCALE 2/1		SHEET 1 OF 1



NOTICE: THIS DRAWING IS A REPRODUCTION OF A DRAWING  
 PREPARED FOR THE GOVERNMENT BY A PRIVATE FIRM.  
 IT IS THE PROPERTY OF THE GOVERNMENT AND IS NOT TO BE  
 REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY  
 MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING,  
 RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL  
 SYSTEM, WITHOUT PERMISSION IN WRITING FROM THE  
 GOVERNMENT. THE GOVERNMENT MAKES NO WARRANTY,  
 EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY,  
 FITNESS FOR A PARTICULAR PURPOSE, OR NON-INFRINGEMENT,  
 IN CONNECTION WITH THE DRAWING OR THE INFORMATION  
 CONTAINED HEREIN. THE GOVERNMENT SHALL NOT BE  
 LIABLE FOR ANY DAMAGES, INCLUDING CONSEQUENTIAL  
 DAMAGES, ARISING OUT OF THE USE OF THE DRAWING OR  
 THE INFORMATION CONTAINED HEREIN.



# FOR PRECISION CASTING:

MATERIAL: NOMINALLY FS4140

\* CARBON 0.35 - 0.45 PER CENT

\* MANGANESE 0.70 - 1.00 " "

\* SILICON 0.25 - 0.70 " "

SULPHUR 0.040 MAX

PHOSPHORUS 0.040 MAX

CHROMIUM 0.80 - 1.10

MOLYBDENUM 0.15 - 0.25

\* PERTAINS TO SCHEDULES  
 ON DWG D7267837 FOR  
 PRECISION CASTINGS.

SPEC MIL-C-10005 (ORD) APPLIES.

CHEMICAL ANALYSIS SHALL BE IN ACCORDANCE WITH SCHEDULES  
 A, B, AND C DWG. D7267837.

THE ACCEPTABLE QUALITY LEVEL FOR RADIOGRAPHIC INSPECTION  
 SHALL BE 0.65 ON A LOT SIZE AS DEFINED ON DWG. D7267837  
 USING LEVEL II OF MIL-STD-105, SINGLE SAMPLING PLAN.

C6147491

DWG D7267837 APPLIES  
 DWG D7266102 APPLIES

ORD PART NO. 6147491

REV	DESCRIPTION	DATE	APPROVAL
A	REDRAWN AND REVISED WAS	28DEC56	J. J. [Signature]
B	" B " SIZE E.O. 5422987		
14		9JUN55	

RELEASE, SEAR

SPRINGFIELD ARMY  
 ORDNANCE CORPS  
 DEPT OF THE ARMY  
 SPRINGFIELD 1, MASS.

6147491

CE

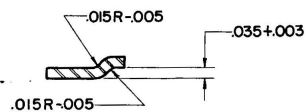
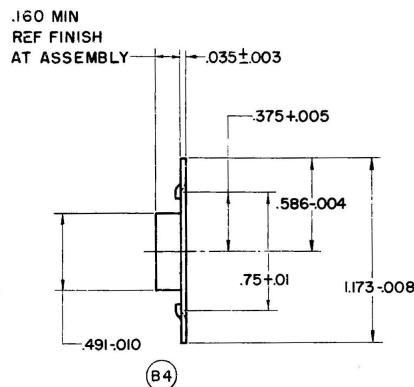
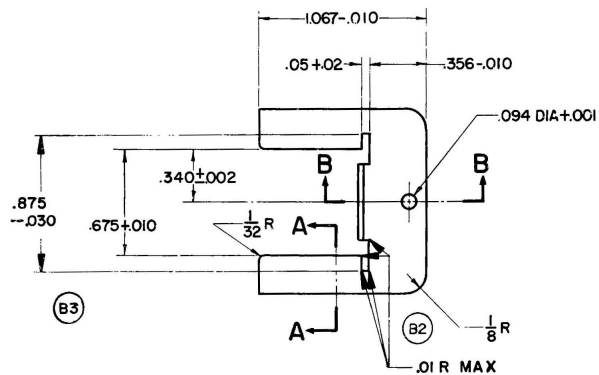
125/ ALL OVER EXCEPT AS NOTED.

CORNERS AND EDGES SHALL BE BROKEN  
 .005+.010X45° UNLESS OTHERWISE SPECIFIED.

PHYSICAL PROPERTIES	F 7265703	30BAR MI918	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE OF DRAWING
TEMP	A2		TOLERANCES ON DECIMALS ±.01	5 JUN 40
EL 2	SEE ENGINEERING RECORDS		ANGLES ±1°	DRAFTSMAN D.E.P. CHECKER J.R.
RA			FRACTIONS ±1/64	TRACER J.A. CHECKER J.W.
BH			MATERIAL STEEL FED SPEC	ENGINEER J. J. [Signature] ENGINEER J. J. [Signature]
HH	C44-47		QQ-S-624: FS 6150 OR FS 8745	SUBMITTED
			HEAT TREATMENT HEAT TO 1600°F, OIL QUENCH, TEMPER TO RH SPECIFIED	ORD CORPS
			FINAL PROTECTIVE FINISH	APPROVED BY ORDER OF THE CHIEF OF ORDNANCE
			TYPE I, SPEC MIL-C-16232	J. J. [Signature]

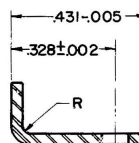
SCALE 2/1 UNIT WT .03

C6147491



SECTION A-A

SCALE  $\frac{4}{1}$



SECTION B-B

SCALE  $\frac{4}{1}$

- NOTES:
1. FINISH  $\sqrt{125}$  EXCEPT SHEARED EDGES  $\sqrt{250}$ .
  2. MATERIAL: STEEL, CR STRIP, TEMPER NO. 3, SPEC QQ-S-698.
  3. BREAK ALL CORNERS AND EDGES .003 + .007 UNLESS OTHERWISE SPECIFIED.

CODE IDENT NO. 19204  
PART NO. 5153154

PHYSICAL PROPERTIES		TOLERANCES ON DECIMALS $\pm .01$		ORIGINAL DATE OF DRAWING 6 NOV 42	
YP	D7265564	30 BAR M1918	ANGLES $\pm 1^\circ$	DRAFTSMAN G.V.S.	CHECKER 3-5
TS		A2	FRACTIONS $\pm 1/64$	TRACER R.P.	CHECKER J.W.
EL 2	SEE ENGINEERING RECORDS		MATERIAL SEE NOTE	ENGINEER R.H.	ENGINEER R.H.
RA			HEAT TREATMENT	SUBMITTED	
BH	NEXT ASSY USED ON		APPLIED AFTER ASSEMBLY	R.H. Henry	
RH	APPLICATION		FINAL PROTECTIVE FINISH	APPROVED BY ORDER OF THE	
	DO NOT	APPLY PART NO.	APPLIED AFTER ASSEMBLY	H.J. Lynch	
	DO	AS SPECIFIED		ORD CORPS	

RETAINER,  
REAR SIGHT  
BASE SPRING

DEPT OF THE ARMY  
ROCK ISLAND, ARSENAL  
ROCK ISLAND, ILL. 61201

DWG SIZE 5153154

C SHEET 1 OF 1

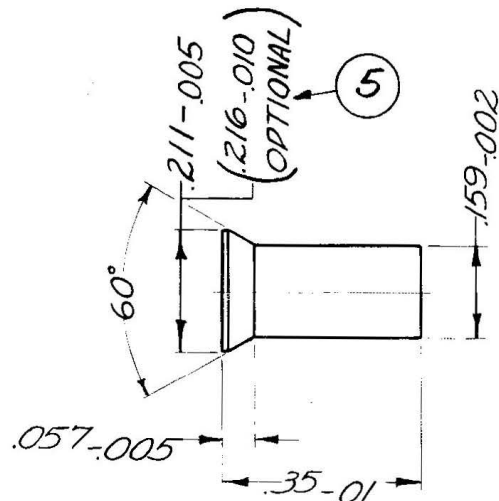
SCALE 2/1 UNIT WT .01

CE 1

HEAT TREATMENT & FINAL FINISH

PROT FIN. AT ASSEMBLY

8



RIVET, BOLT SUPPORT  
STEEL, FED. SPEC QQ-S-633: FS 1035  
FINISH ALL OVER 125

3 5

8

TOLERANCE  $\pm .01$  ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SUPERSEDES OLD TRACING A22243

UNDER REVISION DATE OF JUNE 1, 1936

DWG B7266102 APPLIES

SCALE  $\frac{4}{1}$

DO NOT INSCRIBE PART NO.

PHYSICAL PROPERTIES

Y. P.		1	6-1-36	6'	4-15-44
T. S.		2'	4-15-38	7'	CONVERSION 1-28-49
EL-2		3'	6-1-39	8'	19 AUG 55
RED.		4'	6-25-40		
HT. T.		5'	11-25-43		

7

5

6

3

4

2

5

7

A22243  
MAY 1, 1929.

REVISIONS

DRG. PERTAINS TO

D8770 RECEIVER ASM.  
51-13 30 B.A.R. M-18

51-102 30 B.A.R. M1918A2  
D35472 RECEIVER ASM

D6535472

SYMBOL

HAR 209

D'FTSMAN E. L. J.	TRACER B. J. R.	L'D'G. D'FTSMAN A. J. C.
CHECKER L. S. C.	CHEF D'FTSMAN E. J. C.	

SUBMITTED  
J. J. C.  
CAPT. ORD. DEPT. U.S.A.

APPROVED BY ORDER OF THE  
CHIEF OF ORDNANCE:-  
S. J. Spaulding  
LT. COL. ORD. DEPT. U.S.A.

ORDNANCE DEPT. U.S.A.

SUPERSEDES A22243

A5022243

A22243

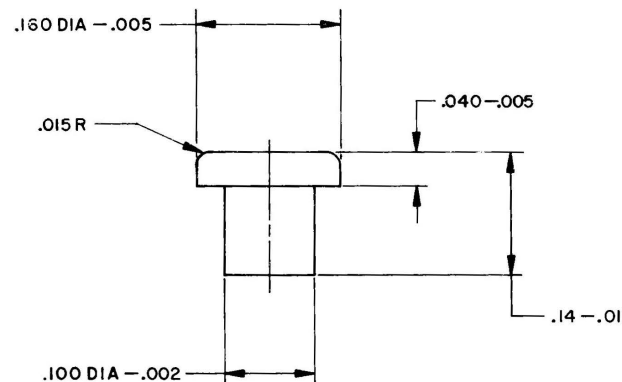
A5022243

1. FINISH  $\sqrt[125]{}$  ALL OVER.

2. ALL EDGES SHALL BE BROKEN .003  
+ .012 UNLESS OTHERWISE SPECIFIED.

3. MATERIAL:  
STEEL, COMP III7, SPEC QQ-S-637.

REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED
A	REDRAWN & REVISED W/CHANGE SEE EO RIA - 14488	25 JAN 88	<i>Karod</i>



PART NO. **5152880**

DEPT OF THE ARMY  
ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201

RIVET, STOP  
LEVER SPRING

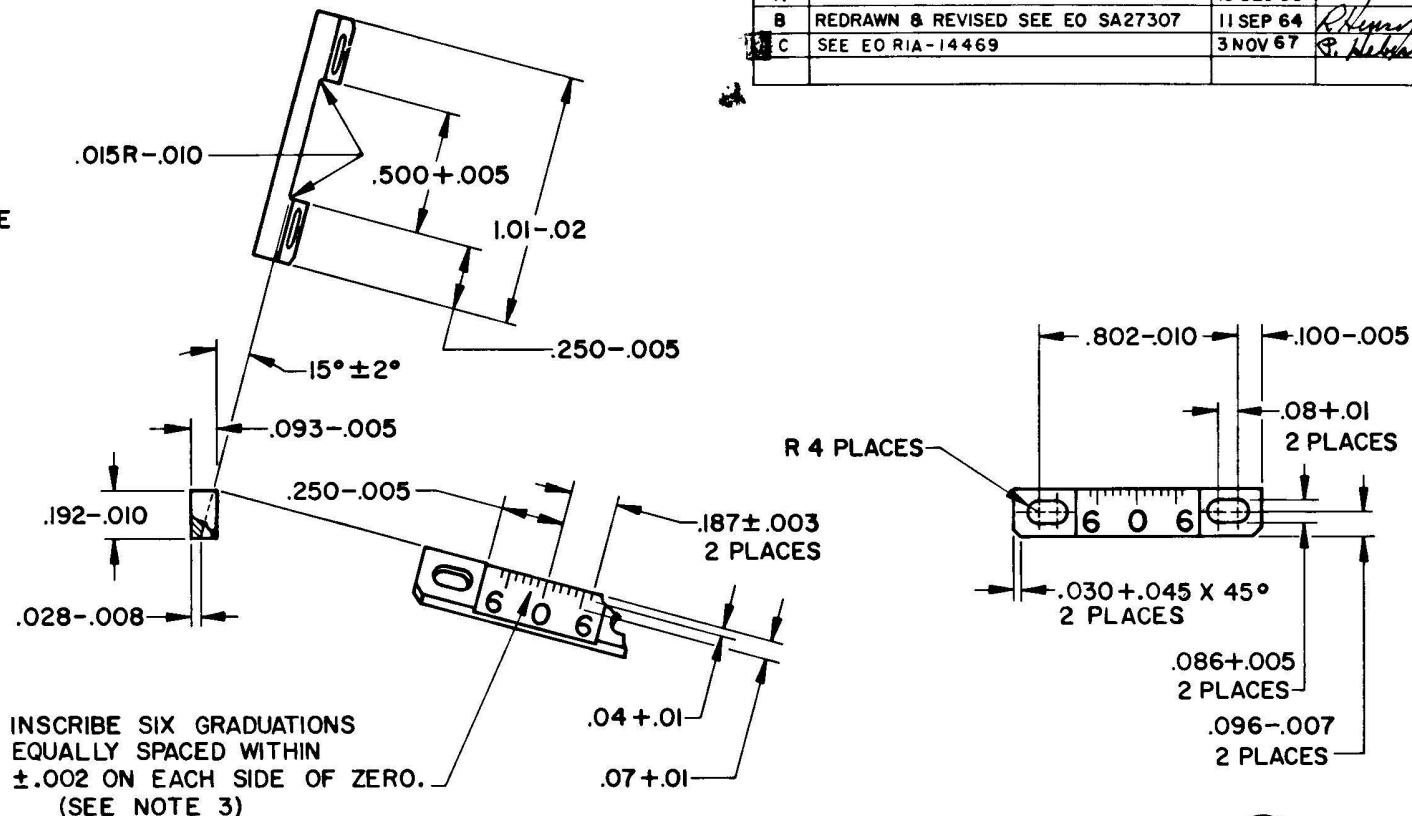
MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 5 JUN 1940		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201			
YP		C6147490	.30 BAR	TOLERANCES ON DECIMALS ± .015		DRAFTSMAN W. L. M.	CHECKER C. H. C.	RIVET, STOP LEVER SPRING			
TS			M1918A2	FRACTIONS ± ANGLES ±		TRACER <i>Ch. K. R. R.</i>	CHECKER <i>E. J. A.</i>				
EL 2		SEE ENGINEERING RECORDS		MATERIAL SEE NOTE 3		ENGINEER <i>C. J. T.</i>	ENGINEER E. J. A.				
RA		NEXT ASSY USED ON		HEAT TREATMENT		SUBMITTED <i>Philip E. Nichols</i>					
BH		APPLICATION		FINAL PROTECTIVE FINISH		APPROVED <i>R. T. Henry</i>		DWG SIZE B		CODE IDENT NO. 19204	5152880
RH		APPLY PART NO.						SCALE 10/1		UNIT WT	SHEET OF

SWESP FORM NO. 1176-3  
20 MAR 64 REV.

NOTICE - WHEN GOVERNMENT DRAWINGS SPECIFICATIONS OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT THEREBY INCURS NO RESPONSIBILITY NOR ANY OBLIGATION WHATSOEVER, AND THE FACT THAT THE GOVERNMENT MAY HAVE FORMULATED, FURNISHED OR IN ANY WAY SUPPLIED THE SAID DRAWINGS SPECIFICATIONS OR OTHER DATA IS NOT TO BE REGARDED BY IMPLICATION OR OTHERWISE AS IN ANY MANNER LICENSING THE HOLDER OR ANY OTHER PERSON OR CORPORATION OR CONVEYING ANY RIGHTS OR PERMISSION TO MANUFACTURE, USE, OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE RELATED THERETO.

# NOTES:

1. FINISH  $\sqrt{25}$ .
2. ALL EDGES AND CORNERS SHALL BE BROKEN  $.003 + .005$  UNLESS OTHERWISE SPECIFIED.
3. GRADUATIONS SHALL BE  $.015 - .007$  WIDE AND  $.005 + .005$  DEEP. FIGURES SHALL BE  $.08$  HIGH AND  $.005 + .005$  DEEP.



PART NO. 5013159

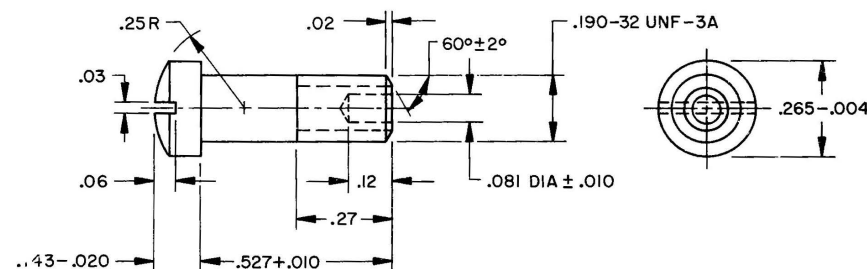
C

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 MAY 29		DEPT OF THE ARMY	
YP		TOLERANCES ON DECIMALS $\pm$		DRAFTSMAN ELJ	CHECKER FB	ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
TS		FRACTIONS $\pm$ ANGLES $\pm 1^\circ$		TRACER go	CHECKER WHS	SCALE, WINDAGE, REAR SIGHT	
EL 2	F6535423 30BARM918A2	MATERIAL: STEEL, FED. SPEC QQ-S-698: CARBON .12 TO .24		ENGINEER T.M. Schuyler	ENGINEER R. S. Henry		
RA	SEE ENGINEERING RECORDS	HEAT TREATMENT NONE		SUBMITTED		CODE IDENT NO.	DWG SIZE
BH	NEXT ASSY USED ON	FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.		APPROVED U.W. Grant		19204	B
RH	DO NOT APPLY PART NO					5013159	
AS SPECIFIED						SCALE 2/1	SHEET 1 OF 1

NOTES:

1. FINISH 125/
2. MATERIAL:  
STEEL, COMP III7, SPEC QQ-S-637.
3. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2 OF  
MIL-STD-171.

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	REDRAWN & REVISED W/CHG SEE EO 82074	27 MAR 68	P. Heberle



PART NO. 5022244

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 MAY 1929		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON DECIMALS .XX ± .01		DRAFTSMAN E. L. J.	CHECKER L. S. C.	SCREW, BRACKET, SWIVEL	
TS		ANGLES ± .XXX ±		TRACER Ave S. Barhill	CHECKER G. Heberle		
EL 2		MATERIAL SEE NOTE 2		ENGINEER G. Heberle	ENGINEER G. Heberle		
RA	C5564073	.30 BAR, M1918 A2		SUBMITTED Philip E. Heberle			
BH		HEAT TREATMENT		APPROVED K. S. Henry		DWG SIZE B	CODE IDENT NO. 19204
RH		FINAL PROTECTIVE FINISH SEE NOTE 3				5022244	
APPLICATION				SCALE 4/1		UNIT WT	SHEET 1 OF 1

SWRI FORM 40B. 1 MAR 67

HEAT TREATMENT & FINAL FINISH

PROT.FIN. TYPE I OR II SPEC MIL-C-16232

PHYSICAL PROPERTIES

Y.P.	X	RED.	X	ROCK.	X
T.S.	X	BR.	X		
EL.2	X				

APRIL 25, 1942

REVISIONS

12	10-12-43	
22	CONC'D BY	
31	9 JUNE 55	
42	19 AUG 55	

DR.G. PERTAINS TO

51-13	30BAR M16
F7265703	30BAR M12/18A2

SCREW BUTT PLATE, LONG

STEEL, FED SPEC QQ-S-633: FS 1117

FINISH ALL OVER 125

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

DWG B7266102 APPLIES

SCALE 2

A153084

A 5153084

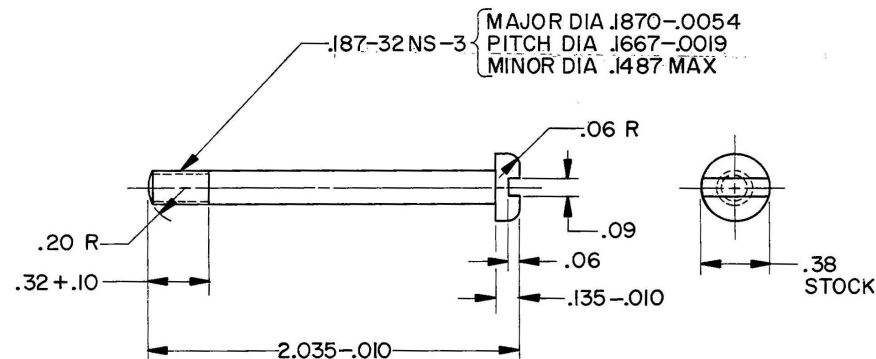
SWESP FORM NO. 1177-1  
20 MAR 64 REV.



NOTES:

1. FINISH  $\sqrt{125}$  ALL OVER.
2. MATERIAL:  
STEEL, COMP 1018, SPEC QQ-S-634  
OR COMP B1112, SPEC QQ-S-637.
3. HEAT TREATMENT:  
HEAT IN CYANIDE AT 1475°-1500°F.  
QUENCH IN WATER. TEMPER AT 400°F.  
FOR 1/2 HOUR. HEAT TREATMENT  
METHOD IS FOR GUIDANCE ONLY  
EXCEPT TEMPERING TIME SHALL NOT  
BE BELOW THAT SPECIFIED.
4. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
5. FILEHARD TEST IN ACCORDANCE  
WITH SA-STD-104.

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	REDRAWN WITH CHANGE SEE EO HRD 92072	13 MAY 69	<i>H. P. P.</i>



PART NO. 5022249

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 MAY 1929	DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON	DECIMALS .XX ± .01	DRAFTSMAN <i>C. J. Hauglin</i>	CHECKER <i>W. S. Garbitt</i>	SCREW, FOREARM, LONG
TS		ANGLES ±	.XXX ±	TRACER <i>C. J. Hauglin</i>	CHECKER <i>W. S. Garbitt</i>	
EL 2		MATERIAL	SEE NOTE 2	ENGINEER <i>H. P. P.</i>	ENGINEER	
RA	F7265703	BAR CAL.30 M1918A2	HEAT TREATMENT SEE NOTE 3	SUBMITTED <i>H. P. P.</i>		
BH		NEXT ASSY.	USED ON	APPROVED <i>V. A. Lunkkonen</i>	DWG SIZE B	CODE IDENT NO. 19204
RH	FILEHARD (SEE NOTE 5)	APPLICATION		FINAL PROTECTIVE FINISH SEE NOTE 4	SCALE 2/1	UNIT WT
					SHEET 1	OF 1



## BQEXI.2

NOMINAL SIZE		#4	#6	#8	#10	#10	#12	1/4	5/16	3/8
THREADS PER INCH		40NC	32NC	32NC	24NC	24NF	24NC	20UNC	18UNC	16UNC
D	DIAMETER OF BODY	MAX .1120 MIN .0925	.1320 .1141	.1640 .1399	.1900 .1656	.1900 .1656	.2160 .1845	.2500 .2127	.3125 .2712	.3750 .3267
A	DIAMETER OF HEAD	SHARP MAX .220 MIN WITH MAX M .200	.275 .257	.336 .308	.395 .365	.395 .365	.470 .437	.507 .477	.635 .605	.752 .722
M	WIDTH OF FLAT	MAX .004	.005	.006	.007	.007	.008	.009	.011	.013
H	HEIGHT OF HEAD	MAX .067 MIN .055	.083 .066	.100 .084	.116 .099	.116 .099	.132 .115	.151 .131	.181 .165	.200 .180
C	TOTAL HEIGHT OF HEAD	MAX .104 MIN .084	.120 .100	.152 .126	.176 .149	.176 .149	.200 .169	.232 .197	.290 .259	.347 .304
J	WIDTH OF SLOT	MAX .039 MIN .031	.040 .030	.054 .045	.060 .050	.060 .050	.067 .055	.071 .062	.082 .072	.094 .081
T	DEPTH OF SLOT	MAX .056 MIN .049	.074 .060	.080 .072	.100 .084	.100 .084	.117 .096	.117 .112	.141 .141	.170 .170

UNDERCUT HEAD		3/16	1/4	5/16	3/8	7/16	1/2	5/8
LENGTH, EQUAL TO OR LESS THAN		3/16	1/4	5/16	3/8	7/16	1/2	5/8
HEIGHT OF HEAD, 2 1/2 APPROX	MAX	.043	.060	.071	.083	.094	.109	.135
DEPTH OF SLOT	MAX	.054	.067	.080	.094	.106	.124	.156
	MIN	.049	.060	.072	.084	.096	.112	.141

L LENGTH	ORDNANCE PART NUMBER - PHOSPHATE (OILED) FINISH									
3/16	134119	134153	134208	134271	134322					
1/4	134124	134197	134213	134276	134327					
5/16	134129	134162	134218	134281	134332					
3/8	134134	134177	134223	134286	134337	134375				
1/2	134139	134182	134228	134291	134342	134380	134418	134456		
5/8	134144	134187	134233	134296	134347	134385	134423	134461	134499	134537
3/4	134149	134192	134238	134301	134352	134390	134428	134466	134504	134542
1 1/4	134154	134197	134243	134306	134357	134395	134433	134471	134509	134547
1 1/2	134159	134202	134248	134311	134362	134400	134438	134476	134514	134552
2	134164	134207	134253	134316	134367	134405	134443	134481	134519	134557
2 1/4										
2 1/2										

**NOMENCLATURE PATTERN:** SCREW, MACHINE, OVAL HEAD, SLOTTED, STEEL, PHOSPHATE (OILED) FINISH, #6-32NC-2A X 1-3/4", PART NO. 134200, DRG NO. BQEXI.2.

**FINISH:** PHOSPHATE COATING SHALL COMPLY WITH TYPE II OF MILITARY SPECIFICATION MIL-C-16232.

**NOTE 1:** LENGTH OF THREAD: ON SCREWS 2" LONG OR SHORTER, THREADS SHALL EXTEND TO WITHIN TWO THREADS OF THE BEARING SURFACE OF THE HEAD. LONGER LENGTHS SHALL HAVE A MINIMUM COMPLETE THREAD LENGTH OF 1-3/4".

**NOTE 2:** OVAL HEAD SCREWS HAVING LENGTHS EQUAL TO OR LESS THAN THOSE GIVEN SHALL HAVE UNDERCUT HEADS.

**NOTE 3:** TOLERANCE ON LENGTH: UP TO 1" MINUS 1/32"; OVER 1" TO 2" MINUS 1/16"; OVER 2" MINUS 3/32".

**PROCUREMENT SPECIFICATION:** FT-S-92

### SUPERSEDES BQEXI.2 W/O CHANGE 12-22-49

REVISIONS				ORIGINAL DATE OF DRAWING JAN 30, 1947		ORDNANCE ENGINEERING STANDARDS (COMMERCIAL)		ORDNANCE DEPT DEPT OF THE ARMY			
SYM	DESCRIPTION	DATE	APPRO	DRAFTSMAN	CHECKER	<b>SCREW, MACHINE, OVAL HEAD CLASS LA STEEL</b>		<b>BQEXI.2</b>			
2	12-22-49	R.F.S.	T.Y.S.	A.B.N.	CHECKER						
3	11-27-53	R.F.S.	ENGINEER	R.F.S.	ENGINEER						
			SUBMITTED	APPROVED							
				MATERIAL							
				STEEL FS-100-1020							
						SCALE		DIMENSIONS IN INCHES			

PHYSICAL PROPERTIES		A5153167	
YP		REVISIONS	
TS			
EL 2		SYM	DESCRIPTION
RA		3	19AUG55
BH		A	REDRAWN AND REVISED
BH		B	(1-3) SEE EO RIA-14 469
BH			3 NOV 67
BH			
BH			

FINISH ALL OVER 125/

FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2  
OF MIL-STD-171

MATERIAL:

STEEL, COMP 1117, 1118 OR  
B1112, SPEC QQ-S-637.

$\frac{9}{64} - \frac{1}{64}$



.032+.005

.025+.010

$\frac{5}{64} - \frac{1}{64}$

230-.015

.10+.02

B3

.086(NO.2)-64-UNF-3A  
MAJOR DIA.0860-0038  
PITCH DIA .0759-0015  
MINOR DIA .0668 MAX

B2

CODE IDENT NO.19204

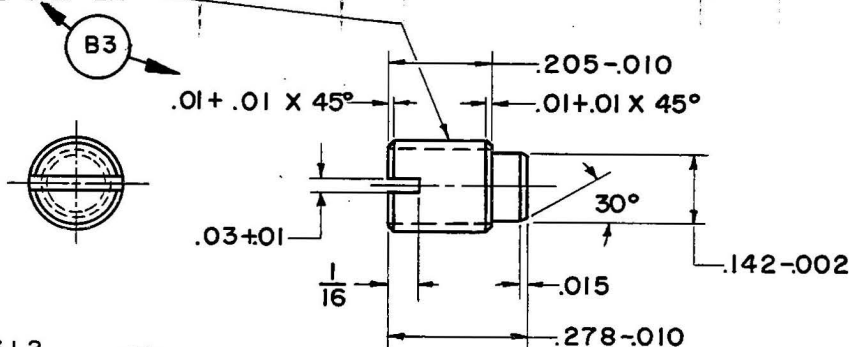
PART NO. 5153167

APPLICATION		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON-	ORIGINAL DATE 18 DEC 42 OF DRAWING		SCREW, REAR SIGHT WINDAGE SCALE	DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 61201
NEXT ASSY	USED ON		DRAFTSMAN	CHECKER		
SEE ENGINEERING RECORDS			TRACER	CHECKER		
F6535423 30 BAR M1918			ENGINEER	ENGINEER		
A2		MATERIAL	SUBMITTER		DWG SIZE A	5153167
A2		SEE NOTE	R. S. Henry			
DO NOT		HEAT TREATMENT	APPROVED BY ORDER OF THE CHIEF OF ORDNANCE			
APPLY PART NO.		FINAL PROTECTIVE FINISH	A. J. Lynch			
AS SPECIFIED		SEE NOTE	ORD CORPS		SCALE 4/1	UNIT WT

PHYSICAL PROPERTIES		A 5013158			
YP		REVISIONS			
TS					
EL 2		SYN	DESCRIPTION	DATE	APPROVAL
RA		15		19 AUG 55	
BH		A	REDRAWN AND REVISED	19 DEC 58	<i>R. S. Henry</i>
RM		B	(1-3) SEE EO RIA-14469	3 NOV 67	<i>P. Hebert</i>

MAJOR DIA .1861-.0060  
PITCH DIA .1658-.0031  
MINOR DIA .1478 MAX

.187-32-UNS-2A



FINISH ALL OVER 125

PROTECTIVE FINISH: FINISH 5.3.1.2  
OF MIL-STD-171

MATERIAL: STEEL, COMP III7, III8 OR  
BIII2, SPEC QQ-S-637.

CODE IDENT NO. 19204 PART NO. 5013158

APPLICATION		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE 1 MAY 29		SCREW, SET, REAR SIGHT BASE		DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 61201	
NEXT ASSY	USED ON	TOLERANCES ON-		OF DRAWING					
SEE ENGINEERING RECORDS		DECIMALS ±.01		DRAFTSMAN GVS. CHECKER SB					
F6535423	30 BAR M198 A2	FRACTIONS ± 1/64		TRACER M. M. CHECKER J. W.					
		ANGLES ± 1°		ENGINEER J. C. ENGINEER J. W.					
		MATERIAL		SUBMITTED					
		SEE NOTE		<i>R. S. Henry</i> ORD CORPS					
		HEAT TREATMENT		APPROVED BY ORDER OF THE CHIEF OF ORDNANCE					
		FINAL PROTECTIVE FINISH SEE NOTE		<i>A. J. Lynch</i> ORD CORPS					
DO NOT		APPLY PART NO.		SCALE 4/1		UNIT WT		DWG SIZE A	
-DO-		-AS SPECIFIED-						5013158	
								SHEET 1 OF 1	

CE



4

3

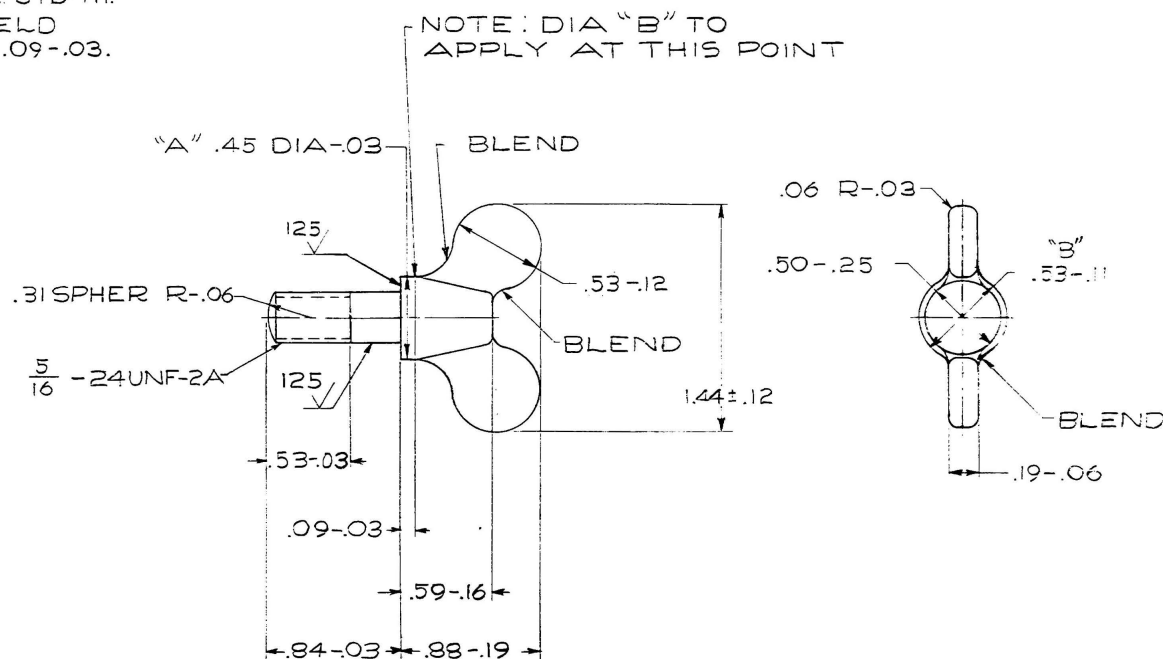
2

1

## NOTE:

1. STEEL, COMP B1112,  
SPEC QQ-S-637.
2. FINISH  $\sqrt{250}$  UNLESS  
OTHERWISE NOTED.
3. BREAK SHARP EDGES  
.003  $\pm$  .012 UNLESS  
OTHERWISE SPECIFIED.
4. FINISH 5.3.1.2 OF MIL-STD-171.
5. DIA "A" MUST BE HELD  
FOR A LENGTH OF .09-.03.

REVISIONS			
MF	ZONE	LTR	DESCRIPTION
			REPLACES REV 9
			W/CHG SEE EC R A-43-9
			DATE 9-13-67
			APPROVED



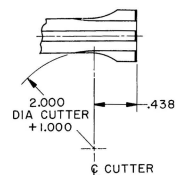
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING JUNE 1, 1939		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON	DECIMALS	DRAFTSMAN	CLEB	CHECKER	RMP
TS		ANGLES $\pm$	.XX $\pm$	TRACER	CH. R. R. R.	CHECKER	
EL 2		MATERIAL	.XXX $\pm$	ENGINEER	RWM	ENGINEER	LUL
RA		SEE NOTE 1		SUBMITTED		SCREW, THUMB	
BH		HEAT TREATMENT		L. J. LONCRINI		DWG SIZE	
RH		FINAL PROTECTIVE FINISH		APPROVED		CODE IDENT NO	
APPLICATION		SEE NOTE 4		H. F. LYNCH		C 19204	
NEXT ASSY.		USED ON		SCALE 2/1		UNIT WT	
						5152774	
						SHEET 2	

NOTES:

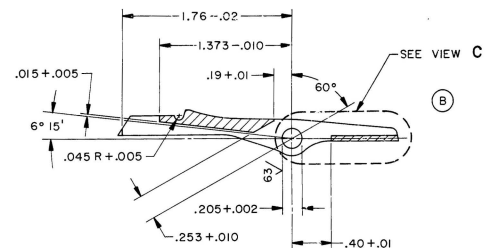
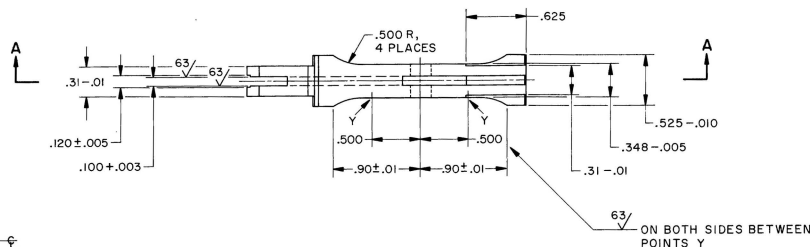
1. FINISH  $\sqrt{125}$  EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .003+.012 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL:  
STEEL, COMP 8640, SPEC QQ-S-624.
4. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171, EXCEPT PARAGRAPH 3.3 OF MIL-P-16232 SHALL NOT APPLY.
5. MIL-W-13255 APPLIES.

(B)

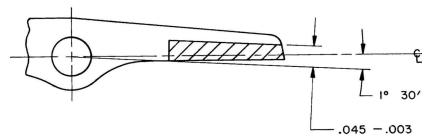
REVISIONS			
REV	DATE	DESCRIPTION	APPROVED
1	25 JAN 68	REDRAWN & REVISED W/CHANGE	<i>K. H. H.</i>
2		SEE EO RIA-14488	
3	02 SEP 75	(S) SEE ERR NGR 10729	<i>K. H. H.</i>



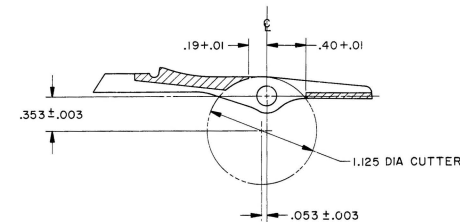
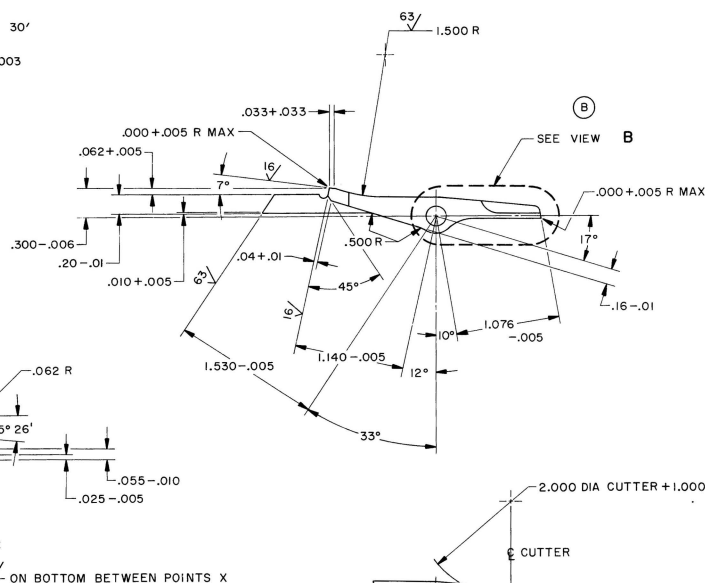
ALTERNATIVE METHOD



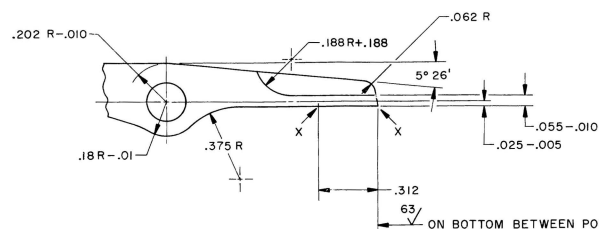
SECTION A-A



VIEW C  
SCALE NONE

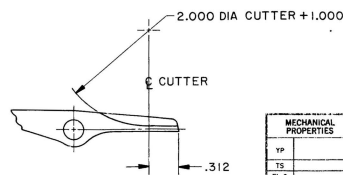


SECTION A-A  
ALTERNATIVE METHOD



(B)

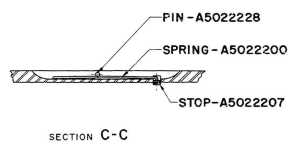
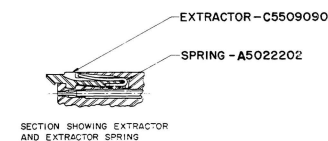
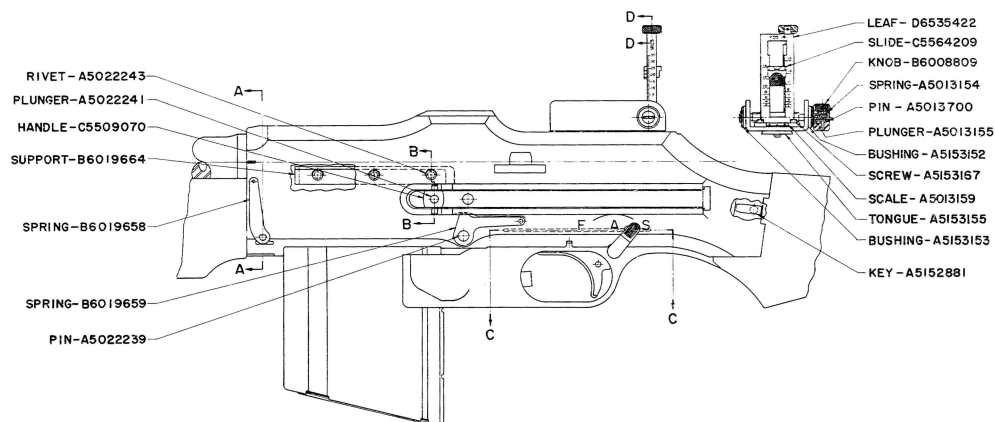
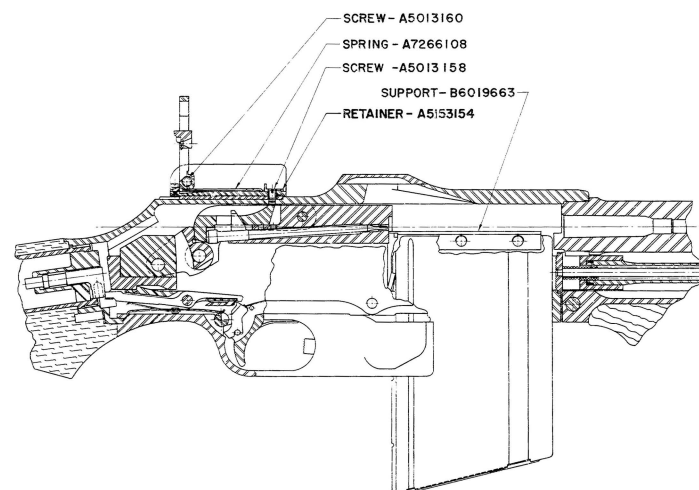
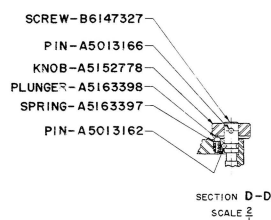
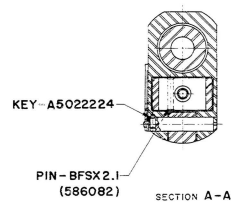
VIEW B  
SCALE 4/1



ALTERNATIVE METHOD

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 5 JUN 1940		PART NO. 5564299	
YP		TOLERANCES ON DIMENSIONS		5 JUN 1940		DEPT OF THE ARMY	
TS		FRACTIONS ON DECIMALS		H J O		ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
EL 2		ANGLES ± 1° 0' .004 ± .015		C J T			
RA		MATERIAL		SUBMITTED			
BH		F6535469 .30 BAR.		BY <i>W. Wilson</i>			
RH		M1918A2		CHECKED <i>W. Wilson</i>			
NEXT ASSY.		USED ON		FINAL PROTECTIVE FINISH		DWG SIZE CODE IDENT NO.	
APPLICATION		SEE NOTE 4		SCALE 2/1		UNIT WT	
						SHEET 1 OF 1	





NOTICE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

CODE IDENT NO. 19204 PART NO. 7265703

PHYSICAL PROPERTIES		PLANT PROTECTANT REGULATED UNDER FIF 241		DATE OF DRAWING: 09 JUN 1990		REVISIONS	
1P	1P	TOLERANCES ON DIMENSIONS: AS SHOWN		OF DRAWING: 09 JUN 1990		RIFLE,	
2P	2P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
3P	3P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		AUTOMATIC, BROWNING,	
4P	4P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		CAL. 30, M1918A2	
5P	5P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
6P	6P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DEPT. OF THE ARMY	
7P	7P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
8P	8P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DEPT. OF THE ARMY	
9P	9P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
10P	10P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DEPT. OF THE ARMY	
11P	11P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
12P	12P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DEPT. OF THE ARMY	
13P	13P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
14P	14P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DEPT. OF THE ARMY	
15P	15P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
16P	16P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DEPT. OF THE ARMY	
17P	17P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
18P	18P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DEPT. OF THE ARMY	
19P	19P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
20P	20P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DEPT. OF THE ARMY	
21P	21P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
22P	22P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DEPT. OF THE ARMY	
23P	23P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
24P	24P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DEPT. OF THE ARMY	
25P	25P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
26P	26P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DEPT. OF THE ARMY	
27P	27P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
28P	28P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DEPT. OF THE ARMY	
29P	29P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
30P	30P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DEPT. OF THE ARMY	
31P	31P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
32P	32P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DEPT. OF THE ARMY	
33P	33P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
34P	34P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DEPT. OF THE ARMY	
35P	35P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
36P	36P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DEPT. OF THE ARMY	
37P	37P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
38P	38P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DEPT. OF THE ARMY	
39P	39P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
40P	40P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DEPT. OF THE ARMY	
41P	41P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
42P	42P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DEPT. OF THE ARMY	
43P	43P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
44P	44P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DEPT. OF THE ARMY	
45P	45P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		ROCK ISLAND ARSENAL	
46P	46P	MATERIAL: 7075-T6 ALUMINUM		FALLS: 7075-T6 ALUMINUM		DE	

U.S. FORM 1176  
1 AUG 68



CORNERS AND EDGES SHALL  
BE FREE FROM BURRS

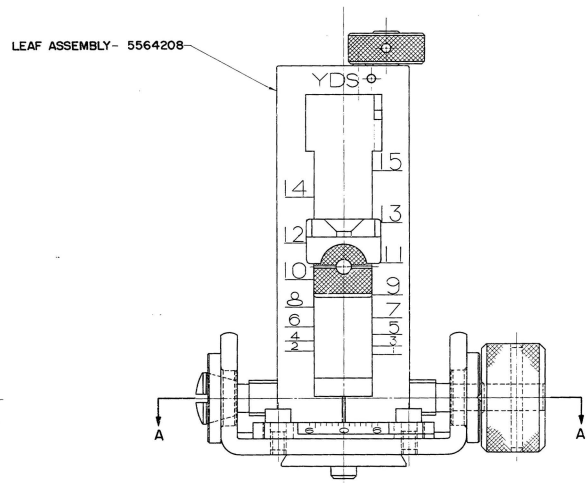
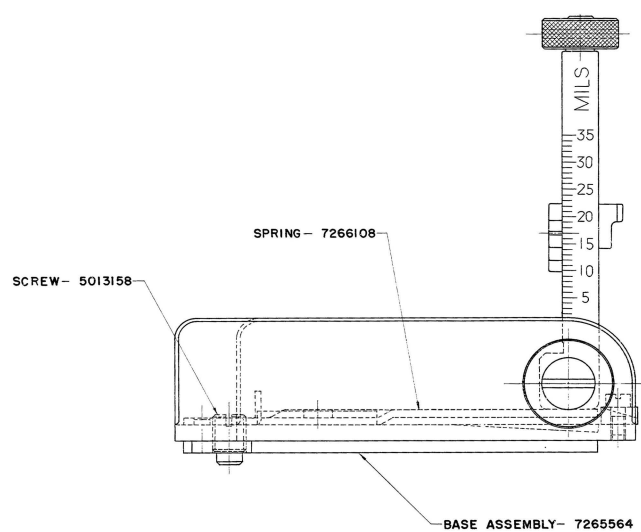
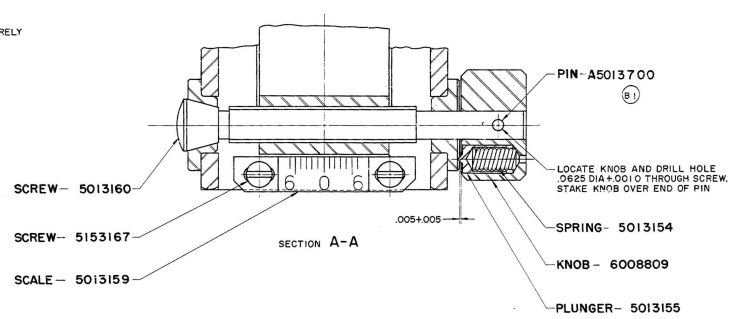
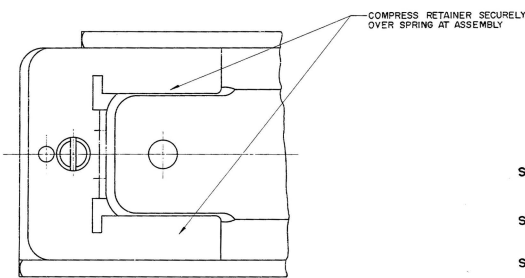
PART NO. 7267379

B'	E.C.O. NO. 22800	SUNES6		
A	E.CO. N022457	IIMAY55		
	SUPERSEDES B6I47323W/C	2 NOV54		
SYM	DESCRIPTION	DATE	APPROVAL	

DWG SIZE B	7267379
------------------	---------

CE

LIST OF COMPONENTS			
LINE NUMBER	DRAWING NUMBER	NAME OF COMPONENT	NUMBER REQUIRED
1	F6535423	SIGHT, REAR, GROUP ASSEMBLY	1
2		COMPOSED OF:-	
3	D7265564	1- BASE, REAR SIGHT, ASSEMBLY	
4	B6008809	1- KNOB, REAR SIGHT, WINDAGE SCREW	
5	D5964208	1- LEAF, REAR SIGHT, ASSEMBLY	
6	A5013700	1- PIN, REAR SIGHT WINDAGE KNOB	
7	A5013155	1- PLUNGER, REAR SIGHT WINDAGE CLICK	
8	B5013159	1- SCALE, WINDAGE, REAR SIGHT	
9	A0153167	2- SCREW, REAR SIGHT WINDAGE SCALE	
10	A5013159	1- SCREW, SET, REAR SIGHT BASE	
11	B5013160	1- SCREW, WINDAGE, REAR SIGHT	
12	B7266108	1- SPRING, REAR SIGHT BASE	
13	B5013154	1- SPRING, REAR SIGHT, WINDAGE CLICK PLUNGER	
14			
15			
16			



NOTE:  
TOUCH UP IN ACCORDANCE  
WITH DRAWING C7792281 (S)

FOR LIST OF PARTS SEE,  
ENGINEERING PARTS LIST 6535423

PHYSICAL PROPERTIES		TOLERANCES ON DIMENSIONS		ORIGINAL DATE OF DRAWING		DEPT OF THE ARMY	
17	F 7265703	18	30 BAR M1918	19	1 JUN 39	20	ROCK ISLAND, ARSENAL
21	JA2	22	JA2	23	1 JUN 39	24	ROCK ISLAND, ILL 61201
25	SEE ENGINEERING RECORDS	26	SEE ENGINEERING RECORDS	27	SEE ENGINEERING RECORDS	28	SEE ENGINEERING RECORDS
29	HEAT TREATMENT	30	HEAT TREATMENT	31	HEAT TREATMENT	32	HEAT TREATMENT
33	DO NOT APPLY PART NO.	34	DO NOT APPLY PART NO.	35	DO NOT APPLY PART NO.	36	DO NOT APPLY PART NO.
37	FINAL PROTECTIVE FINISH	38	FINAL PROTECTIVE FINISH	39	FINAL PROTECTIVE FINISH	40	FINAL PROTECTIVE FINISH

SIGHT, REAR, GROUP ASSEMBLY		DEPT OF THE ARMY	
ROCK ISLAND, ARSENAL		ROCK ISLAND, ILL 61201	
F 6535423		F 6535423	

REDUCED SIZE PRINT

# HEAT TREATMENT & FINAL FINISH

PROT. FINISH: TYPE I OR II, SPEC. MIL-C-16232

USE  $\frac{5}{32}$  DRILL TO REMOVE PIN FROM THIS HOLE AFTER BRAZING

NOTE: THIS DRAWING IS A REVISION OF THE PREVIOUS EDITION. IT IS THE RESPONSIBILITY OF THE USER TO BE AWARE OF THE CHANGES AND TO OBTAIN THE LATEST EDITION. THE USER IS ADVISED THAT THE DRAWING IS NOT TO BE USED FOR THE DESIGN OF NEW EQUIPMENT OR FOR THE REPAIR OF EXISTING EQUIPMENT WITHOUT THE APPROVAL OF THE AUTHORITY ISSUING THE DRAWING.

STOP-B 147484

.041 BRAZING WIRE

FACE AFTER BRAZING

$\frac{3}{32}$  R

$\frac{3}{32}$

$20 \pm .02$

BEFORE BRAZING DRILL & PIN FINISH FLUSH BOTH SIDES .0395 (.39) DRILL

NOTE - ALTERNATIVE DESIGN. THE BRAZING WIRE GROOVES ARE ELIMINATED. BRACE OR SILVER SOLDER COLLAR AND STOP TO BODY. THE .0395(.39) DRILL HOLE AND  $\frac{3}{32}$  DRILL TO REMOVE PIN FROM HOLE MAY BE OMITTED. CAUTION: THE BRAZING AND SILVER SOLDER MATERIAL MUST NOT RUN DOWN ON THE THREADED SECTION OF THE STOP.

FACE AFTER BRAZING

PIN-BFOX4 (505297)

4.42-.02 FINISHED LENGTH

COLLAR-A 152882

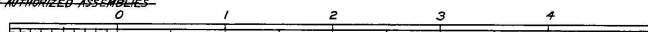
BODY - B 147483

SLEEVE, STOCK RETAINING ASSEMBLY C-64298-2 5564298

## LIST OF COMPONENTS

1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NO REQUIRED PER UNIT ASM
1	C 64298	SLEEVE, STOCK RETAINING ASSEMBLY	1
2		COMPOSED OF:-	
3	A 152882	1-COLLAR, SLEEVE STOCK RETAINING	
4	B 147483	1-PIN, STRAIGHT, STEEL (PLAIN FINISH)	
5	B 147483	1-BODY, STOCK RETAINING SLEEVE	
6	B 147484	1-STOP, ACTUATOR	

\* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES - TOLERANCE  $\pm .01$  ALLOWED ON ALL DIMENSION UNLESS OTHERWISE SPECIFIED.



5 INCHES

C5564298

C-64298

## PHYSICAL PROPERTIES

Y.R.	1	2	3	4	5	6	7	8	9
1	12-28-41	9-18 AUG 55							
2	10-16-41								
3	12-12-42								
4	3-1-43								
5	11-7-44								
6	2-18-45								
7	7-26-49								
8	9 JUNE 55								

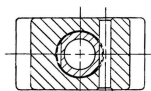
DRG PERTAINS TO

FT266703 30 BAR-M1918-A2

SUPERSEDES C64298

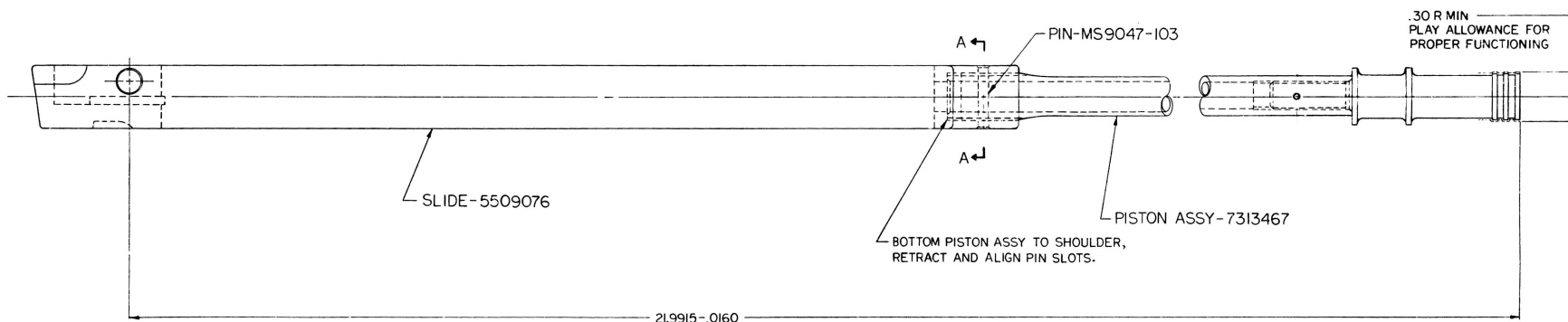
NOTES:  
1. MIL-W-13855 APPLIES.

REVISIONS			
NO	DESCRIPTION	DATE	APPROVED
1	REPLACES REV A WITH CHANGE	21 SEPT 75	
2	SEE NOR 75-00014-0005		



PEEN MATERIAL OF SLIDE OVER  
PIN ON BOTH ENDS.

SECTION A-A

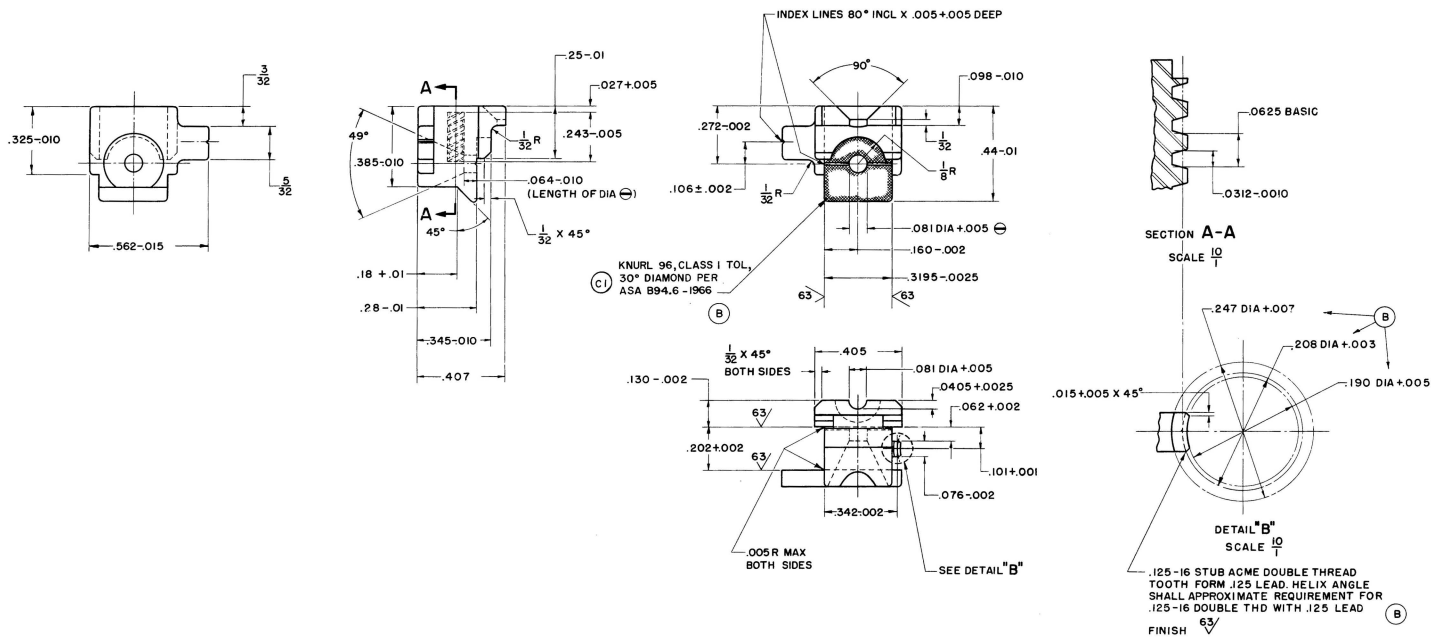


SEE EPL-7313513

PART NO. 7313513

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING	DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201
Y1	MIN	TOLERANCES ON	DECIMALS	24 OCT 45	SLIDE, ASSEMBLY
Y2	MAX	ANGLES &	XXX &	21 SEPT 75	
EL-2		MATERIAL		21 SEPT 75	
RA		TREATMENT		21 SEPT 75	
BH	F726570.3	RIFLE, CAL. 30		21 SEPT 75	F 19204 7313513
RH	MIDIBA2 (BAR)			21 SEPT 75	
NEXT ASSY		USED ON	FINAL PROTECTIVE FINISH	APPROVED	SCALE 2/1 UNIT WT
APPLICATION				D. D. G.	





D5564209

NOTES:

1. MATERIAL: STEEL, COMP 1117, 1118, OR B1112, SPEC QQ-S-637.

2. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171.

3. ALL OVER EXCEPT AS NOTED

4. EXTERIOR CORNERS AND EDGES SHALL BE BROKEN .010+.015 X 45° OR .010R+.015

PHYSICAL PROPERTIES D5564208 30 BAR M1918 A2 SEE ENGINEERING RECORDS NEXT MEET USED ON APPLICATION DO NOT APPLY PART NO. 100-1000000		TOLERANCES ON DECIMALS ±.01 FRACTIONS ±1/64 MATERIAL SEE NOTE 1 HEAT TREATMENT FINAL PROTECTIVE FINISH SEE NOTE 2		ORIGINAL DATE 1 JUN 29 OF DRAWING CHECKED BY E. H. R. CHECKER TRACER BY R. H. CHECKER ENGINEER BY R. H. CHECKER DUBININ BY R. H. CHECKER APPROVED BY R. H. CHECKER DATE 1 JUN 29 SCALE 4/1 UNIT INT. OI CE		REVISIONS DEPT OF THE ARMY ROCK ISLAND, ARSENAL ROCK ISLAND, ILL. 61201 D5564209 SHEET 1 OF 1	
---	--	---	--	--	--	--	--

REDUCED SIZE PRINT



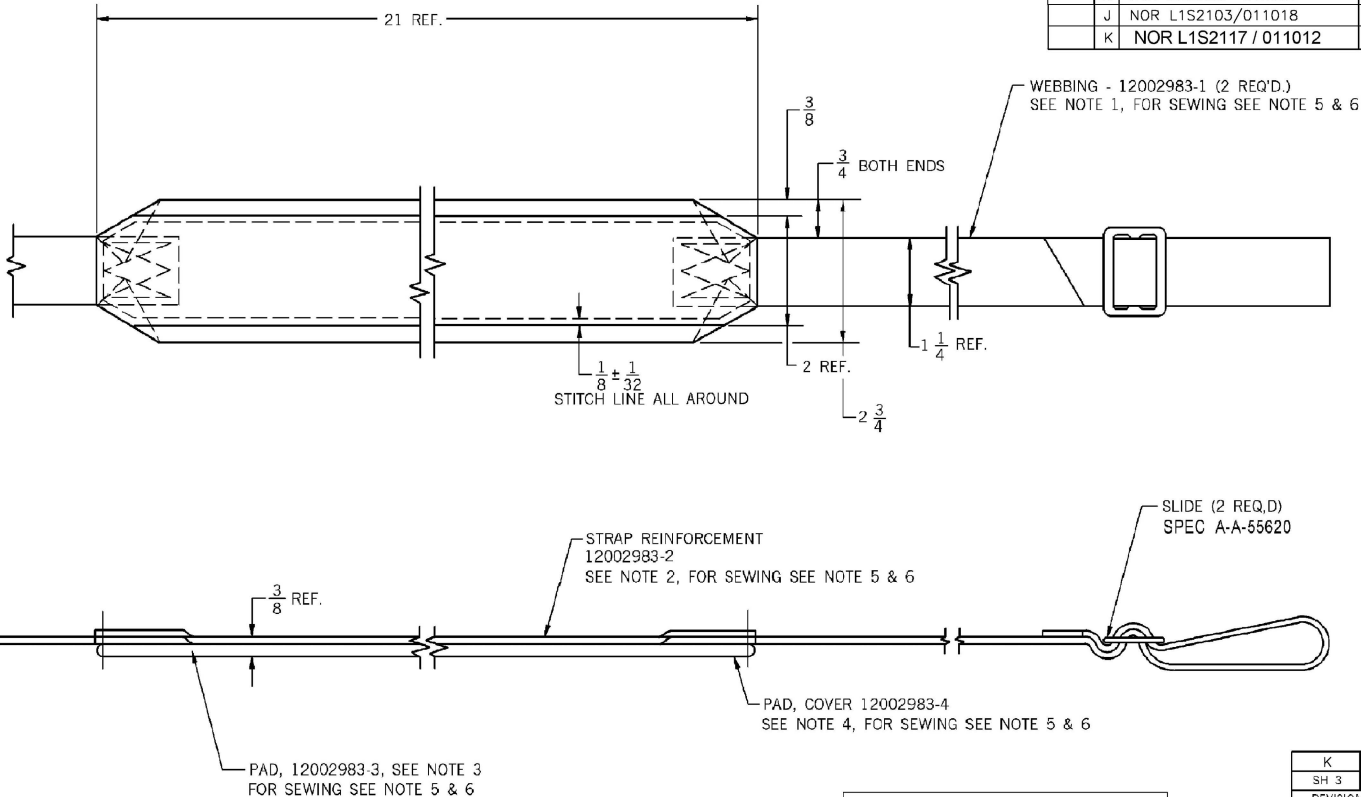


AMSWE Form 403D, 13 Nov 70

NOTE:

1. WEBBING, TEXTILE, BULKED NYLON, TYPE II, A-A-55301. COLOR BLACK, NO. 37038 OF FED-STD-595.
2. WEBBING TEXTILE, WOVEN NYLON, TYPE VIII b, CLASS II OF MIL-W-4088. WEBBING SHALL BE RESIN IMPREGNATED CONFORMING TO CLASS R TREATMENT OF MIL-W-27265. COLOR BLACK NO. 37038 OF FED-STD-595.
3. CLOTH, SPACER (OLEFIN) OF MIL-C-43204, COLOR OPTIONAL.
4. CLOTH, DUCK, NYLON, TYPE III, CLASS 3, OF PIA-C-7219. COLOR BLACK NO. 37038 OF FED-STD-595. THIS COMMERCIAL SPECIFICATION IS AVAILABLE THROUGH PARACHUTE INDUSTRY ASSOCIATION, 3833 WEST OAKTON STREET, SKOKIE, IL 60076
5. THE THREAD FOR ALL STITCHING SHALL CONFORM TO TYPE I, CLASS I, SUB-CLASS A OR B OF V-T-285. WHEN SUB-CLASS B THREAD IS USED THE NON-WICKING REQUIREMENTS SHALL NOT APPLY. COLOR SHALL BE BLACK AA (C 66043) AND SHOW FASTNESS TO WEATHERING EQUAL TO OR BETTER THAN THE STANDARD SAMPLE. SIZE F THREAD SHALL BE USED FOR ALL STITCHING.
6. ALL STITCHES, SEAMS AND STITCHING SHALL BE PERFORMED USING STITCH TYPE 301 WITH 7 TO 9 STITCHES PER INCH IN ACCORDANCE WITH ASTM D6193.
7. MIL-W-13855 APPLIES.

REVISIONS				
ZONE	LTR	DESCRIPTION	DATE (OR MO DA)	APPROVED
	A	SEE ERR HQR 30758	BODY 73	<i>[Signature]</i>
	B	Q2 SEE ERR HQR 40455	3 AUG 74	<i>[Signature]</i>
	C	NDRW952012 75-05-15	79C 716	<i>[Signature]</i>
	D	NOR W6S0031 / 860416	941025	DTC
	E	NOR L8S2013 / 980803	980803	JB
	F	NOR L8S2029 / 991207	991217	BAC
	G	NOR L9S5104 / 990715 (ECP L9S5107 / 991018)	000307	DTC
	H	NOR L1S2080 010605	010621	RLV
	J	NOR L1S2103 / 011018	020422	HJS
	K	NOR L1S2117 / 011012	020429	DTC



CURRENT DESIGN ACTIVITY CASE CODE 19200  
U.S. ARMY  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
PICATINNY ARSENAL, NEW JERSEY 07806-5000

K	K	K
SH 3	SH 2	SH 1
REVISION STATUS OF SHEETS		

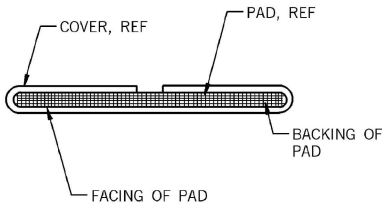
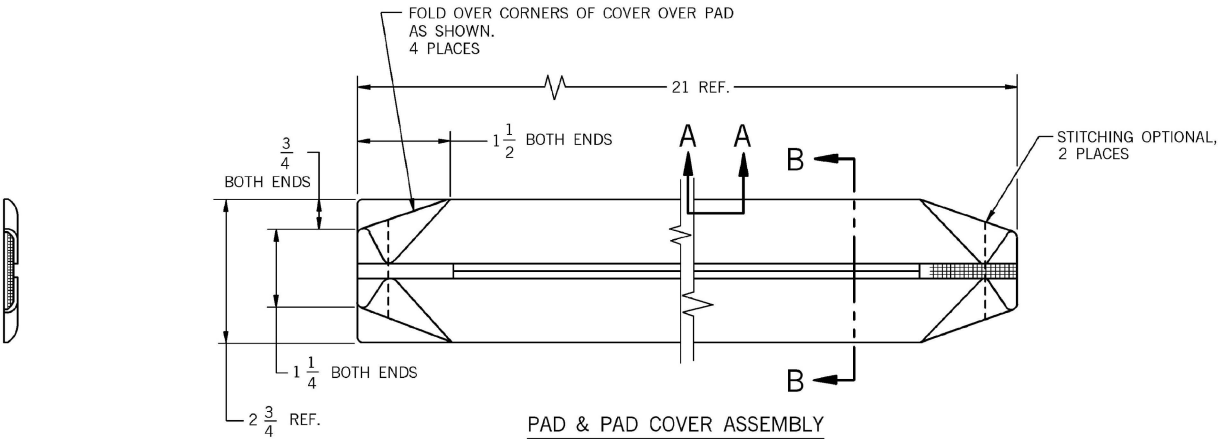
SEE SEPARATE PARTS LIST - 12002983

PART NO. 12002983

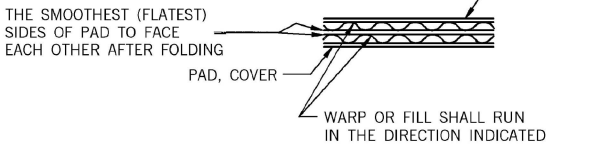
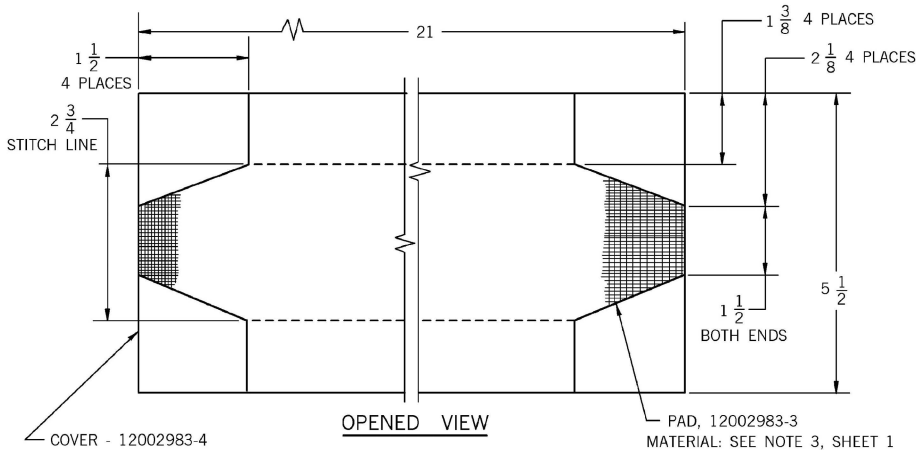
MECHANICAL PROPERTIES		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCE ON DECIMAL FRACTION 2 PL ± 1/16 3 PL ± 1/32		CONTRACT NO.		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
93013A0000	MG, M240G			DATE 27 SEPT 73		SLING, PADDED ADJUSTABLE	
12978815	MG, M240D			DRAWN BY		DATE 19204	
F7265703	M1918A2			CHECKER		12002983	
F7791009	MG 7.62 N/M			SUBMITTED		SCALE 1/1 UNIT WT.	
F7269100	M60			APPROVED		SHEET 1 OF 3	
9348199	M249 M.G.						
NEXT ASSY	USED ON						
APPLICATION		FINAL PROTECTIVE FINISH					

DISTRIBUTION STATEMENT A.  
APPROVED FOR PUBLIC RELEASE;  
DISTRIBUTION IS UNLIMITED.

REVISIONS			
ZONE	LTR	DESCRIPTION	DATE (YR MO DA)
A		SEE ERR HQR 30758	8 NOV 73
B		(2) SEE ERR HQR 10455	9 AUG 74
C		NORW9S 2012 79-05-15	79C 716
G		NOR L9S5104 / 990715 (ECP L9S5107 / 991018)	000307
K		NOR L1S2117 / 011012	020429



SECTION B-B  
SCALE: 2/1



SECTION A-A  
SCALE: 4/1

CURRENT DESIGN ACTIVITY CAGE CODE 19200  
U.S. ARMY  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PART NO. 12002983

			DO NOT SCALE DRAWING		CONTRACT NO.		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201				
		93013A0000	MG. M240G	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCE ON DECIMAL FRACTION		DATE: 27 SEPT 73		SLING, PADDED ADJUSTABLE			
MECHANICAL PROPERTIES		12976815	MG. M240B	2 PL ± ± 1/16		DRAWN BY <i>CHANDLER</i> DATE (YR-MO-DA)					
YB	TS	F7265703	M1918A2	3 PL ±		CHECKER <i>FCB</i> ENGINEER <i>RSB</i>		SIZE		CAGE CODE	
EL2		F7791009	MG 7.62 MM	MATERIAL		SUBMITTED <i>Swickard</i>		D		19204	
RA	BH	F7269100	M60	SEE NOTES		APPROVED <i>Swickard</i>		12002983			
		9348199	M249 M.G.					SCALE 1 / 1		UNIT WT.	
		NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH				SHEET 3		OF 3	
RH		APPLICATION									

DISTRIBUTION STATEMENT A.  
APPROVED FOR PUBLIC RELEASE;  
DISTRIBUTION IS UNLIMITED.

4

3

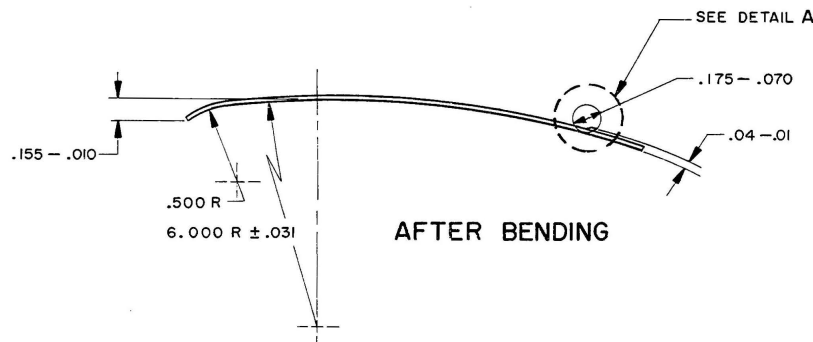
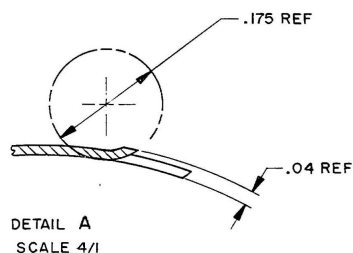
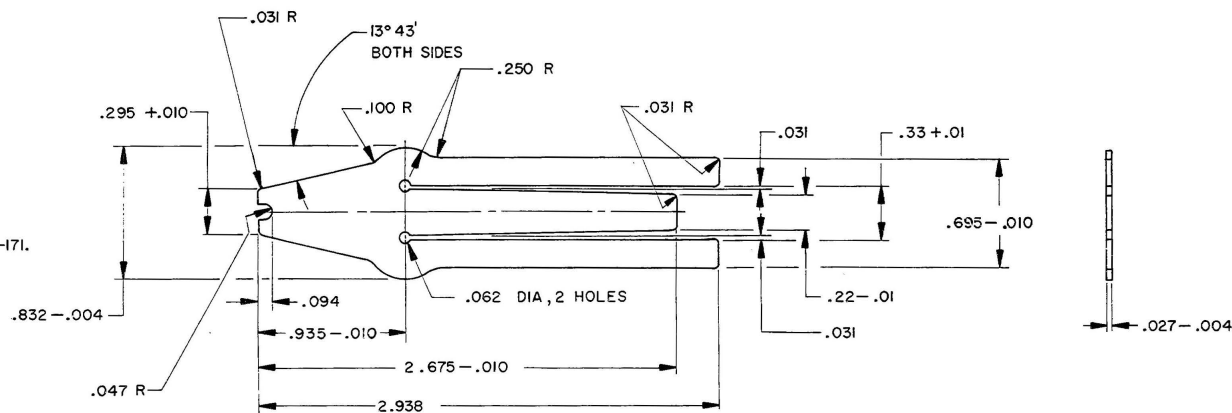
2

1

## NOTES:

1. FINISH  $\sqrt{125}$  EXCEPT SHEARED EDGES  $\sqrt{250}$ .
2. ALL EDGES SHALL BE BROKEN  $.003 + .012$  UNLESS OTHERWISE SPECIFIED.
3. MATERIAL:  
STEEL, COMP 1095, SPEC QQ-S-777.
4. HEAT TREATMENT:  
HEAT AT  $1500^{\circ}$  TO  $1550^{\circ}$  F FOR 3 TO 5 MINUTES. OIL QUENCH. TEMPER 45 MINUTES TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE ONLY EXCEPT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	REDRAWN & REVISED W/CHG	25 JAN 68	<i>Kennel</i>
			SEE EO RIA-14488		



PART NO. 6019662

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 MAY 1929		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON	DECIMALS	DRAWN BY	CHECKER	SPRING, SEAR	
TS		ANGLES ±	.XX ±	D. E. R.	F. E. V.		
EL 2		MATERIAL	.XXX ± .015	TRACER	CHECKER		
RA		SEE NOTE 3		ENGINEER	ENGINEER		
BH	F6535469	HEAT TREATMENT	SEE NOTE 4	SUBMITTED		DWG SIZE CODE IDENT NO. C 19204 6019662	
RH	A72 TO 74.5	FINAL PROTECTIVE FINISH	SEE NOTE 5	APPROVED			
APPLICATION				R. J. Henry		SCALE 2/1 UNIT WT SHEET 1 OF 1	

NOTICE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHERE AUTHORIZED BY THE UNITED STATES GOVERNMENT PROCUREMENT.

HEAT TREATMENT & PROT. FINISH  
TEMPER AT APPROXIMATELY 350°F FOR 1 1/2 HOUR

DO NOT INSCRIBE PART NO.

PHYSICAL PROPERTIES

A22251  
MAY 1, 1929.

REVISIONS

Y. P.	1	6-1-30	6'	4-15-44
T. S.	2'	4-15-38	7'	CONVERSION 1-28-49
EL-2	3'	6-1-39	8'	10-27-52
RED.	4'	3-13-42	9'	3-5-53
HT. T.	5'	10-12-43	10'	2 NOV 54
BR.	DRG. PERTAINS TO			
SCL.	54-13 30 BAR M10			
C. C.	FT265703 30 BAR-M1918A2			
REVISIONS	11' 9 JUNE 55			

SYMBOL

PAS 461

DFTSMAN ELJ TRACER L. J. O. DFTSMAN  
CHECKER J. B. J. O. DFTSMAN  
SUBMITTED: J. B. J. O. DFTSMAN

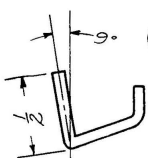
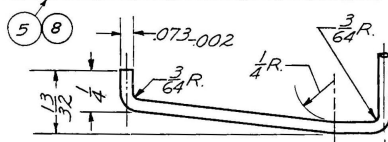
CAPT. ORD. DEPT. U.S.A.

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:-  
S. I. Spalding

LT. COL. ORD. DEPT. U.S.A.

ORDNANCE DEPT. U.S.A.

SUPERSEDES A22251



REVISIONS  
11' 9 JUNE 55

APPROX. AFTER SETTING.

SPRING BOLT GUIDE  
STEEL SPEC MIL-W-13604:  
FS1085A

3.0R ± 1/4

DWG B7266102 APPLIES

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.  
SUPERSEDES OLD TRACING A22251  
UNDER REVISION DATE OF JUNE 1, 1936.

SCALE?

A5022251

A22251

A5022251

4

3

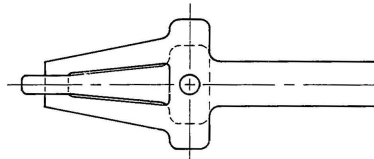
2

1

## NOTE:

I. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2  
OF MIL-STD-171.

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	REDRAWN & REVISED W/CHANGE SEE EO RIA-14488	25 JAN 68



SPRING-6147489

RIVET-5152880

SPRING-6147488

.105 MAX.

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST - 6147490

PART NO. 6147490

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 5 JUN 1940		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON DECIMALS .XX ±		DRAFTSMAN W.L.M.	CHECKER C.H.C.	SPRING, CHANGE AND STOP LEVER, ASSEMBLY	
TS		ANGLES ± XXX ±		TRACER V. J. B. B. B.	CHECKER E. J. A.		
EL 2		MATERIAL		ENGINEER C. J. T.	ENGINEER E. J. A.		
RA		HEAT TREATMENT		SUBMITTED Philip E. Hebert			
BH	F6535469	30 B.A.R.		APPROVED R. S. Henry		DWG SIZE C	CODE IDENT NO. 19204
RH		NEXT ASSY.	USED ON	FINAL PROTECTIVE FINISH SEE NOTE 1		SCALE 2/1	UNIT WT
APPLICATION						SHEET 1 OF 1	

HEAT TREATMENT & FINAL FINISH

DO NOT INSCRIBE PART NO

PHYSICAL PROPERTIES

MAY 1, 1929  
REVISIONS

Y.P.  
T.S.  
EL-2  
RED.  
HT.T.  
BR.  
SCL.  
C.C.

1 6-1-36  
2 4-15-38  
3 6-1-39  
4 6-25-40  
5 4-15-44  
6 1-28-49

DRG. PERTAINS TO

B-9770 RECEIVED ASSEMBLY  
5-13 30 B.A.R. M-10  
5-10 30 B.A.R. M-10  
B-5472 RECEIVER, A3M  
D6535472

SYMBOL

PYS-7

DFTSMAN  
E.L.J.  
CHECKER  
2.4.6

TRACER  
2.4.6  
L.D.G. DFTSMAN  
A.Y.C.  
CHIEF DFTSMAN  
2.4.6

APPROVED BY ORDER OF THE  
CHIEF OF ORDNANCE  
5.4.6  
LT. COL. ORD. DEPT. U.S.A.

ORDNANCE DEPT. U.S.A.

B6019697

SQUEEZE SIDES TOGETHER SLIGHTLY TO RETAIN SPRING

SPRING-A22200

STOP-A22207

SPRING, CHANGE LEVER STOP, ASSEMBLY (6019697)

LIST OF COMPONENTS

1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NUMBER REQUIRED
1	B 19697	SPRING, CHANGE LEVER STOP, ASSEMBLY	(1)
2		COMPOSED OF:	
3	A 22200	1-SPRING, CHANGE LEVER STOP	
4	A 22207	1-STOP, CHANGE LEVER	

\* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES  
SUPERSEDES OLD TRACING B19697 UNDER REVISION DATE OF JUNE 1, 1936.

B6019697

B19697

SUPERSEDES B19697

THIS DRAWING SHALL NOT BE USED OR REPRODUCED IN ANY MANNER OR IN PART EXCEPT BY AUTHORITY OF THE UNITED STATES GOVERNMENT PROCUREMENT.

NOTICE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

HEAT TREATMENT & PROT FINISH  
TEMPER AT APPROXIMATELY 350°F FOR 1/2 HOUR

DO NOT INSCRIBE PART NO

PHYSICAL PROPERTIES

Y. P.  
T. S.  
EL-2  
RED.  
HT. T.

A22200  
MAY 1, 1929

REVISIONS

1	6-1-36	6	7-28-49
2	4-15-38	7	10-27-52
3	6-1-39	8	3-5-53
4	10-12-43	9	2 NOV 54
5	4-15-44		

DRG. PERTAINS TO

BR.  
SCL.  
C. C.

B19691 SPRING CHANGE  
51-13 LEVER STOP ASM  
51-102 30 B.A.R. M-18  
51-102 30 BAR-M1918A2

SYMBOL

PAS 464

DFTSMAN  
ELN  
CHECKER  
SUBMITTED

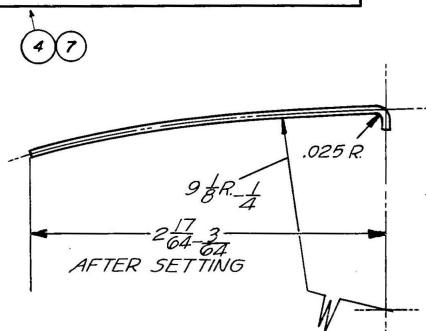
TRACER  
L. J. B.  
L. J. B.

L'DG DFTSMAN  
O. J. C.  
CHIEF DFTSMAN  
M. J. C.

APPROVED BY ORDER OF THE  
CHIEF OF ORDNANCE:  
S. I. Spaulding  
LT. COL. ORDN. DEPT. U.S.A.

ORDNANCE DEPT. U.S.A.

SUPERSEDES A22200



SPRING, CHANGE LEVER STOP

STEEL, SPEC MIL-W-13604: FS1085 A

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.  
SUPERSEDES OLD TRACING A22200  
UNDER REVISION DATE OF JUNE 1, 1936

DWG B7266102 APPLIES

A5022200

A22200

SCALE 2

A5022200



4

3

2

1

## NOTES:

1. FINISH 125/ EXCEPT SHEARED EDGES 250/.

2. ALL EDGES SHALL BE BROKEN .003 ± .012  
UNLESS OTHERWISE SPECIFIED.

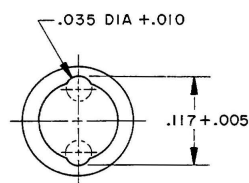
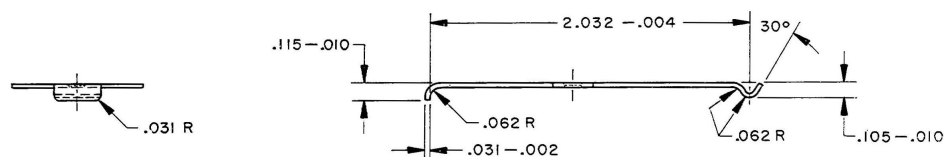
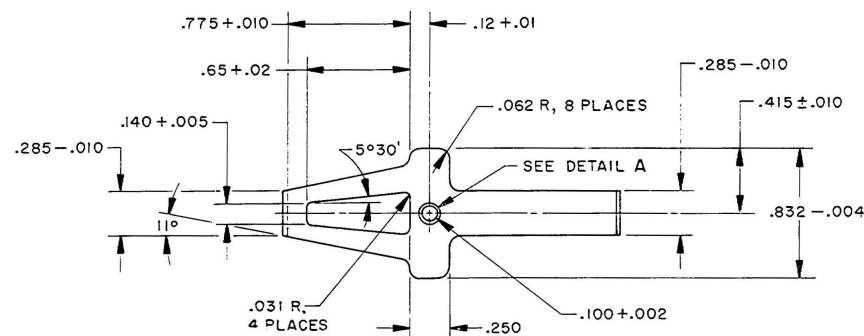
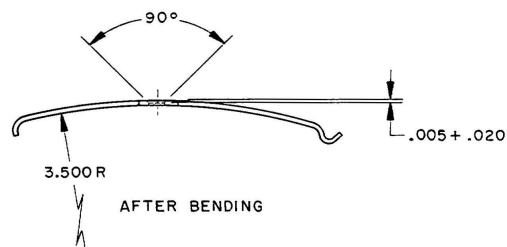
## 3. MATERIAL:

STEEL, COMP 1055 OR 1065, SPEC QQ-S-777.

## 4. HEAT TREATMENT:

HEAT AT 1500° TO 1550° F FOR 3 TO 5  
MINUTES. OIL QUENCH. TEMPER 45  
MINUTES TO HARDNESS SPECIFIED.  
HEAT TREATMENT METHOD IS FOR  
GUIDANCE ONLY EXCEPT TEMPERING  
TIME SHALL NOT BE REDUCED BELOW  
THAT SPECIFIED.

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	REDRAWN & REVISED W/CHANGE SEE EO RIA-14488	25 JAN 68

DETAIL A  
SCALE 10/1

PART NO. 6147488

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 5 JUN 1940		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL 61474	
YP		TOLERANCES ON DECIMALS		DRAFTSMAN	WLM	CHECKED	CHC
TS		ANGLES ± 1°	XXX ± .015	TRAINER	WLM	CHECKED	WLM
EL 2		MATERIAL		ENGINEER	CJT	ENGINEER	EJA
RA		SEE NOTE 3		SUBMITTED		Philip E. Helms	
BH	C6147490	.30 B.A.R. M1918A2		HEAT TREATMENT		SEE NOTE 4	
RH	A72 TO 74.5	NEXT ASSY. USED ON		FINAL PROTECTIVE FINISH		APPROVED	
APPLICATION				R. S. Henry			

SPRING, CHANGE LEVER

DWG SIZE CODE IDENT NO  
C 19204 6147488

SCALE 2/1 UNIT WT

NOTES:

1. MATERIAL:  
WIRE, MUSIC, SPEC QQ-W-470.
2. HEAT TREATMENT:  
STRESS RELIEVE AT  $450^{\circ} \pm 25^{\circ}$  F  
FOR 30 MINUTES AFTER FORMING.
3. FINAL PROTECTIVE FINISH:  
LUBRICATING OIL, SPEC VV-L-800.
4. SPRING FUNCTIONS OVER ROD .166 MAX.

OUTSIDE DIA SOLID, NOT MORE THAN \_\_\_\_\_ .400  $\pm$  .005  
 INSIDE DIA FREE, NOT LESS THAN \_\_\_\_\_ .210  
 ASSEMBLED HEIGHT BASIC \_\_\_\_\_ .650  
 LOAD AT ACSEMBLED HEIGHT \_\_\_\_\_ 85.  $\pm$  5. LBS  
 SOLID HEIGHT, NOT MORE THAN \_\_\_\_\_ .560  
 DIA OF WIRE (APPROX) \_\_\_\_\_ .090  
 FREE HEIGHT (APPROX) \_\_\_\_\_ .770  
 NUMBER OF COILS (APPROX) \_\_\_\_\_ 6  
 DIRECTION OF COILING \_\_\_\_\_ L.H.  
 ENDS PLAIN AND GROUND FLAT  
 OPERATING HEIGHT BASIC \_\_\_\_\_ .580  
 LOAD AT OPERATING HEIGHT \_\_\_\_\_ 125.0  $\pm$  7.5 LBS  
 SPRING RATE (REF) \_\_\_\_\_  
 MANUFACTURE IN ACCORDANCE WITH MIL-S-13572,  
 TYPE I, GRADE A.

REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	REDRAWN & REVISED W/CHANGE SEE EO RIA-14488	25 JAN 68	<i>Hamelin</i>

PART NO. 5153133

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 15 AUG 1942		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON DECIMALS XX $\pm$		DRAFTSMAN R. S.	CHECKER M. E. K.	SPRING, COUNTER RECOIL	
TS		ANGLES $\pm$ XXX $\pm$		TRACER <i>C. E. R. [Signature]</i>	CHECKER <i>[Signature]</i>		
EL 2		MATERIAL	SEE NOTE 1	ENGINEER E. C. P.	ENGINEER E. J. A.	DWG SIZE	CODE IDENT NO.
RA	F 6535469	.30 B.A.R.	HEAT TREATMENT	SUBMITTED <i>Philip E. Heberle</i>		B	19204
BH		M 1918A2	SEE NOTE 2	APPROVED <i>R. J. Henry</i>		5153133	
RH		NEXT ASSY. USED ON	FINAL PROTECTIVE FINISH	SCALE		UNIT WT	SHEET 1 OF 1
		APPLICATION	SEE NOTE 3				

5

4

3

2

1

## NOTES:

1. MATERIAL:  
WIRE, MUSIC, SPEC QQ-W-470.
2. HEAT TREATMENT:  
STRESS RELIEVE AT  $450^{\circ} \pm 25^{\circ} \text{ F}$   
FOR 30 MINUTES AFTER FORMING.
3. FINAL PROTECTIVE FINISH:  
LUBRICATING OIL, SPEC VV-L-800.
4. SPRING FUNCTIONS IN HOLE .172 MIN.
5. SPRING FUNCTIONS OVER ROD .095 MAX.
6. CLOSE END COIL TO .075+.005 I.D.
7. EXPAND OTHER END COIL TO  
.186-.006 O.D.

OUTSIDE DIA SOLID, NOT MORE THAN \_\_\_\_\_ .165  
 INSIDE DIA FREE, NOT LESS THAN \_\_\_\_\_ .107  
 ASSEMBLED HEIGHT BASIC \_\_\_\_\_ .590  
 LOAD AT ASSEMBLED HEIGHT \_\_\_\_\_  $1.40 \pm 0.25 \text{ LBS}$   
 SOLID HEIGHT, NOT MORE THAN \_\_\_\_\_ .380  
 DIA OF WIRE (APPROX) \_\_\_\_\_ .021  
 FREE HEIGHT (APPROX) \_\_\_\_\_ .770  
 NUMBER OF COILS (APPROX) \_\_\_\_\_ 15.5  
 DIRECTION OF COILING \_\_\_\_\_ L.H.  
 ENDS CLOSED  
 OPERATING HEIGHT BASIC \_\_\_\_\_ .450  
 LOAD AT OPERATING HEIGHT \_\_\_\_\_  $2.6 \pm 0.4 \text{ LBS}$   
 SPRING RATE (REF) \_\_\_\_\_  
 MANUFACTURE IN ACCORDANCE WITH MIL-S-13572,  
 TYPE I, GRADE B.

## REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	REDRAWN & REVISED W/CHANGE SEE EO RIA-14488	25 JAN 68	<i>Karodis</i>

PART NO. 5153132

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 15 AUG 1942		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON	DECIMALS	DRAFTSMAN	CHECKER	SPRING, EJECTOR LOCK	
TS		ANGLES $\pm$	$\times \times \pm$	R. S.	M. E. K.		
EL 2		MATERIAL	SEE NOTE 1	<i>Philip E. Seberle</i>	<i>John S. Henry</i>		
RA	F6535469	.30 B A R	HEAT TREATMENT	E. C. P.	E. J. A.		
BH		M1918A2	SEE NOTE 2	SUBMITTED		DWG SIZE	CODE IDENT NO.
RH		NEXT ASSY. USED ON	FINAL PROTECTIVE FINISH	APPROVED		B	19204
APPLICATION		SEE NOTE 3		<i>Philip E. Seberle</i> <i>R. J. Henry</i>		5153132	
				SCALE		UNIT WT	SHEET 1 OF 1

SWER! FORM 40B. 1 MAR 67

NOTICE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED ENTIRELY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

HEAT TREATMENT & PROT FINISH  
TEMPER AT APPROXIMATELY 350°F FOR 1/2 HOUR

DO NOT INSCRIBE PART NO.

PHYSICAL PROPERTIES

MAY 1, 1929

REVISIONS

Y. P.	1	6-1-36	6	4-15-44
T. S.	2	4-15-38	7	1-28-45
EL-2	3	6-1-39	8	10-27-52
RED.	4	3-13-42	9	3-5-53
HT. T.	5	10-12-43	10	2 NOV 54

DRG. PERTAINS TO

REVISIONS  
II 9 JUNE 55

BR.	5113	30BAR-M18
SCL.		
C. C.	F7265703	30BAR-M1918AZ

SYMBOL

PAS 466

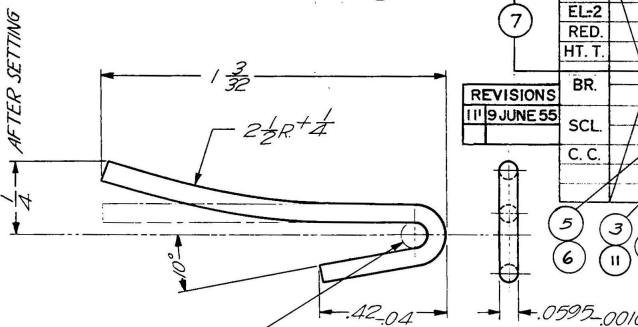
DFTSMAN	TRACER	L'D.G. DFTSMAN
ELJ	W.A.	0.90
CHECKER	W.A.	0.90
2.8.6	W.A.	0.90

SUBMITTED  
CAPT. ORD. DEPT. U.S.A.

APPROVED BY ORDER OF THE  
CHIEF OF ORDNANCE:  
S.I. Spalding  
LT COL., ORD. DEPT. U.S.A.

ORDNANCE DEPT. U.S.A.

SUPERSEDES A22202



SPRING, EXTRACTOR

STEEL, SPEC MIL-W-13604-FS1085A

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.  
SUPERSEDES OLD TRACING A22202  
UNDER REVISION DATE OF JUNE 1, 1936

DWG B7266102 APPLIES

SCALE 4

A5022202

A22202

A5022202

4

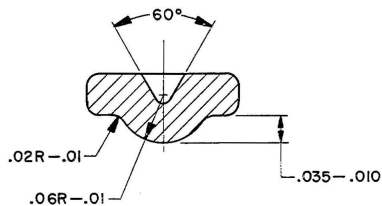
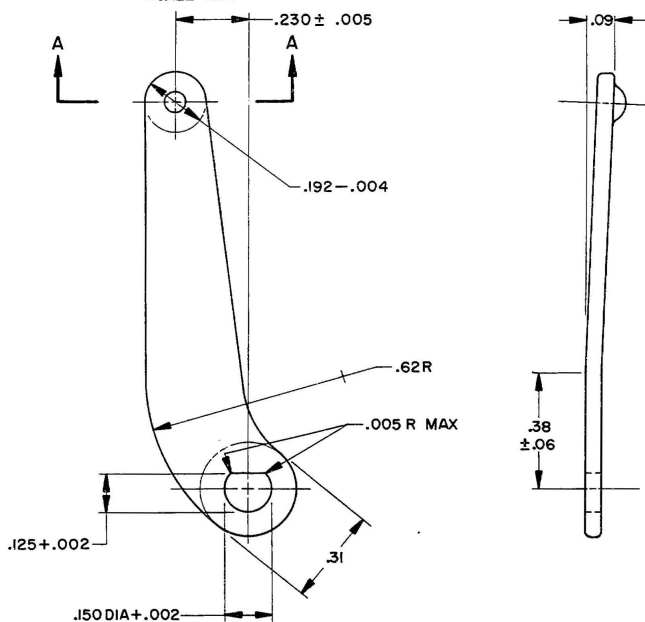
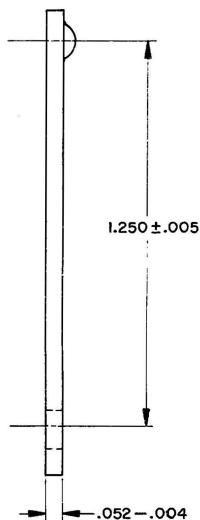
3

2

1

## NOTE:

1. FINISH  $\sqrt{25}$ .
2. BREAK ALL EDGES  $.005 + .010$  UNLESS OTHERWISE SPECIFIED.
3. STEEL, COMP 1095, SPEC QQ-S-777.
4. HEAT AT 1450° TO 1475°F. OIL QUENCH. TEMPER 30 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE ONLY EXCEPT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.

SECTION AA  
SCALE 10/1DEVELOPMENT  
IN THE FLAT

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	REPLACES REV 11 W/CHANGE	
			SEE EO RIA-14433	4 OCT 67
				APPROVED

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 MAY 1929		DEPT OF THE ARMY	
YP		TOLERANCES ON DECIMALS		DRAFTSMAN	CHECKER	ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
TS		ANGLES ± 1°		E. L. J.	L. S. C.	SPRING	
EL 2		MATERIAL		TRACER	CHECKER		
RA		SEE NOTE 3		T. Ring	W. Wilson		
BH		HEAT TREATMENT		ENGINEER	ENGINEER	DWG SIZE CODE IDENT NO. 6019658	
RH	C 45 - 50	SEE NOTE 4		A. N. W.	E. W. H.		
		FINAL PROTECTIVE FINISH		SUBMITTED			
		APPLICATION		APPROVED		SCALE 4/1	SHEET OF
				S. P. SPALDING		UNIT WT	

NOTES:

1. WIRE, STEEL, CARBON,  
SPRING, MUSIC,  
SPEC QQ-W-470.

OUTSIDE DIA SOLID, NOT MORE THAN \_\_\_\_\_ 1.115  
INSIDE DIA FREE, NOT LESS THAN \_\_\_\_\_ .71  
ASSEMBLED HEIGHT BASIC \_\_\_\_\_ .98  
LOAD AT ASSEMBLED HEIGHT \_\_\_\_\_ 166 LBS  $\pm$  10  
SOLID HEIGHT, NOT MORE THAN \_\_\_\_\_ .825  
DIA OF WIRE \_\_\_\_\_ .180  $\pm$  .001  
FREE HEIGHT (APPROX) \_\_\_\_\_ 1.27  
NUMBER OF COILS (APPROX) \_\_\_\_\_ 4.5  
DIRECTION OF COILING \_\_\_\_\_ LEFT HAND  
ENDS OPEN AND GROUND \_\_\_\_\_  
OPERATING HEIGHT BASIC \_\_\_\_\_  
LOAD AT OPERATING HEIGHT \_\_\_\_\_  
SPRING RATE (REF) \_\_\_\_\_ 571 LBS  
MANUFACTURE IN ACCORDANCE WITH  
MIL-S-13572, TYPE I, GRADE A

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
1	A		REPLACES REV 7 WITH CHANGE SEE ERR HQR		
			30786	11 JAN 74	E. Winter

PART NO. 5153131

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 15 AUG 42		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YS MIN		TOLERANCES ON	DECIMALS	DRAFTSMAN	CHECKER	SPRING, HELICAL, BUFFER	
YS MAX		ANGLES $\pm$	XXX $\pm$	D. Padalino	B. Malheur		
EL 2		MATERIAL		TRACER	CHECKER	DWG SIZE CODE IDENT NO. B 19204 5153131	
RA	F7265703	SEE NOTE 1		ENGINEER	E. Winter		
BH		HEAT TREATMENT		SUBMITTED		SCALE NONE UNIT WT SHEET 1 OF 1	
RH		FINAL PROTECTIVE FINISH		APPROVED			
APPLICATION				A. L. Cole			

NOTES: WHEN GOVERNMENT DRAWINGS SPECIFICATIONS OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT, THE UNITED STATES GOVERNMENT THEREBY INCURS NO RESPONSIBILITY NOR ANY OBLIGATION WHATSOEVER. THE FACT THAT THE GOVERNMENT MAY HAVE FORMULAS, SPECIFICATIONS OR OTHER DATA IS NOT TO BE CONSIDERED BY THE HOLDER OR ANY OTHER PERSON OR CORPORATION IMPLYING ANY RIGHTS, PERMISSION TO MANUFACTURE, USE OR SELL ANY INVENTED INVENTION THAT MAY IN ANY BE INVENTED HEREIN.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
C		28 SEP 60	
D	REDRAWN AND REVISED SEE EO SA27441	2 NOV 64	<i>R. Henry</i>
E	(1) SEE EO SA 29262	18 MAY 66	<i>R. Henry</i>
F	(1-2) SEE EO 82048	11 MAR 68	<i>R. Henry</i>
G	(1) SEE EO HRD 92078-2	25 JUN 69	<i>R. Henry</i>
H	SEE EO HRD 02138	71 FEB 75	<i>R. Henry</i>
J	SEE ERR HQR 40681	10 FEB 75	<i>R. Henry</i>
K	NOR W8S2022/79-03-26	79-04-01	<i>SA R. H. H.</i>
L	NORW4S2051/840824 ECPW5S2069 /851223	860121	<i>R. Henry</i>

WIRE DIAMETER ----- .0410 ± .0005  
 COIL DIAMETER ( O.D. ) ----- .240 ± .005  
 FREE LENGTH ----- .69 REF  
 TOTAL COILS ----- 9 REF  
 DIRECTION OF HELIX ----- R H  
 LOAD AT COMPRESSED LENGTH OF .47 ----- 17.5 LB ± 2 LB  
 LOAD AT COMPRESSED LENGTH OF .42 ----- 21.5 LB ± 3 LB  
 SPRING RATE ----- 80 LB/IN REF  
 SOLID LENGTH ----- .380 MAX  
 TYPE OF ENDS ----- CLOSED ENDS GROUND  
 MANUFACTURE IN ACCORDANCE WITH MIL-S-13572, TYPE I, GRADE A.

NOTES:

(J)

- HOLE DIA INTO WHICH SPRING FITS FREELY .257 MIN.
- ROD DIA OVER WHICH SPRING SLIDES FREELY MAX.
- HEAT TREATMENT: STRESS RELIEVE AT 425 °F. TO 445 °F. FOR 30 MIN, AFTER COILING.
- LOAD REQUIREMENTS SHALL APPLY AFTER SPRING HAS BEEN COMPRESSED TO SOLID LENGTH 3 TIMES.

ORIGINAL FSCM NO.19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
 U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
 DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES		D7790686 RIFLE, M14		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 21 FEB 35		U.S. ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 61204	
		C7313114 30BARM1918							
YP		A2		TOLERANCES ON DECIMALS ±		DRAFTSMAN D.S.K.		CHECKER A.A.C.	
TS				FRACTIONS ± ANGLES ±		TRACER J. H. S.		CHECKER J. H. S.	
EL 2				MATERIAL: STEEL, WIRE, SPEC QQ-W-470		ENGINEER J. H. S.		ENGINEER J. H. S.	
RA				HEAT TREATMENT SEE NOTE 3		SUBMITTED			
BH		NEXT ASSY USED ON		FINAL PROTECTIVE FINISH LUB OIL, SPEC VV-L-800		APPROVED			
RH		APPLICATION				J. H. S.			
		DO NOT APPLY PART NO				J. H. S.			
		AS SPECIFIED				J. H. S.			

SPRING, HELICAL,  
COMPRESSION

CODE-DEPT-NO.	DWG SIZE	
19204	B	5013747
SCALE	UNIT WT	SHEET   OF

5		4		3		2		1	
						REVISIONS			
MF	ZONE	LTR	DESCRIPTION			DATE	APPROVED		
AA	-	A	REPLACES REV 5 WITH CHNG, SEE EPR HQR 20712			6 JUL 72	<i>E. Hunter</i>		
<p>SPRING FUNCTIONS IN HOLE _____ .400 MIN. REF</p> <p>MAXIMUM OUTSIDE DIA. AT MINIMUM OPERATING HEIGHT _____ .370</p> <p>MINIMUM INSIDE DIAMETER, FREE _____ .30!</p> <p>WIRE DIAMETER _____ .0220</p> <p>COIL DIAMETER (O.D) FREE _____ .355 ± .005 REF</p> <p>FREE LENGTH _____ 11.00 REF</p> <p>TOTAL COILS _____ 77 REF</p> <p>DIRECTION OF HELIX _____ OPTIONAL</p> <p>LOAD AT COMPRESSED LENGTH OF 5.52 _____ .67 LBS ± .07 LBS</p> <p>LOAD AT COMPRESSED LENGTH OF 2.00 _____ 1.10 LBS ± .11 LBS</p> <p>SPRING RATE REF _____ .128 LBS PER INCH</p> <p>SOLID LENGTH _____ 1.86 MAX</p> <p>TYPE OF ENDS _____ OPEN ENDS GROUND</p> <p>MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE A, MIL-S-13572</p>									
(USED WITH ACTUATOR - 6147486)									
MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
YS	MIN			TOLERANCES:		DATE 6 JUL 72		SPRING, HELICAL, COMPRESSION	
YS	MAX			ANGLES ± —		PREP <i>R. L. Barry</i>			
EL 2				3 PLACE DECIMALS ± —		CHK <i>R. L. Barry</i>			
RA				2 PLACE DECIMALS ± —		ENGR <i>E. Hunter</i>			
BH				MATERIAL		SUBMITTED <i>D. J. Cole</i>			
RH				STEEL, MUSIC WIRE, SPEC QQ-S-470		APPROVED		SIZE CODE IDENT NO. DRAWING NO.	
		F 7265703	MI918A2 BAR CAL...30	FINAL PROTECTIVE FINISH				B	19204 5153134
		APPLICATION						SCALE SHEET OF	



NOTES:

1. STEEL, CRES, CMPSN 302, FORM I, CONDITION B, SPEC QQ-W-423.
2. STRESS RELIEF, SPEC MIL-S-13572.

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		C	REPLACE REV B W/CHANGE	
			SEE ERR HQR 50616	26 FEB 75
				<i>E. Hunter</i>

OUTSIDE DIA SOLID, NOT MORE THAN \_\_\_\_\_ .126  
 INSIDE DIA FREE, NOT LESS THAN \_\_\_\_\_ —  
 ASSEMBLED HEIGHT BASIC \_\_\_\_\_ .357  
 LOAD AT ASSEMBLED HEIGHT \_\_\_\_\_ 2.0 ± .2 LB  
 SOLID HEIGHT, NOT MORE THAN \_\_\_\_\_ .230  
 DIA OF WIRE (APPROX) \_\_\_\_\_ .019  
 FREE HEIGHT (APPROX) \_\_\_\_\_ .49  
 NUMBER OF COILS (APPROX) \_\_\_\_\_ 11.5  
 DIRECTION OF COILING \_\_\_\_\_ OPTIONAL  
 ENDS OPEN AND GROUND FLAT  
 OPERATING HEIGHT BASIC \_\_\_\_\_ .230  
 LOAD AT OPERATING HEIGHT \_\_\_\_\_ —  
 SPRING RATE (REF) \_\_\_\_\_ 15.0  
 MANUFACTURE IN ACCORDANCE WITH MIL-S-13572, TYPE I, GRADE A.

PART NO. 7266090

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 23 MAY 51		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YS MIN		TOLERANCES ON	DECIMALS XX ±	DRAFTSMAN <i>Plummer</i>	CHECKER	SPRING, HELICAL, PLUNGER	
YS MAX		ANGLES ±	XXX ±	TRACER	CHECKER		
EL 2		MATERIAL	SEE NOTE 1	ENGINEER <i>E. Hunter</i>	ENGINEER	DWG SIZE CODE IDENT NO. B 19204 7266090	
RA		HEAT TREATMENT	SEE NOTE 2	SUBMITTED <i>Donald J. B. Littlewood</i>			
BH		FINAL PROTECTIVE FINISH		APPROVED <i>D. A. Cole</i>		SCALE NONE UNIT WT SHEET 1 OF 1	
RH		APPLICATION					

SARRI Form 40B, 1 May 74

5	4	3	2	1				
<p>NOTE: WIRE, MUSIC, SPEC QQ-W-470.</p>			REVISIONS					
			MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
					A	REPLACES REV 7 W/CHG		
						SEE EO RIA-14393	9-14-67	WCH
<p>OUTSIDE DIA SOLID, NOT MORE THAN _____ .336</p> <p>INSIDE DIA FREE, NOT LESS THAN _____ .229</p> <p>ASSEMBLED HEIGHT BASIC _____ 11.00</p> <p>LOAD AT ASSEMBLED HEIGHT _____ 9.6 LB ± 1.0 LB</p> <p>SOLID HEIGHT, NOT MORE THAN _____ 5.90</p> <p>DIA OF WIRE (APPROX) _____ .043</p> <p>FREE HEIGHT (APPROX) _____ 16.50</p> <p>NUMBER OF COILS (APPROX) _____ 130</p> <p>DIRECTION OF COILING _____ RH</p> <p>ENDS CLOSED AND GROUND FLAT</p> <p>OPERATING HEIGHT BASIC _____ 6.00</p> <p>LOAD AT OPERATING HEIGHT _____ 18.3 LB ± 1.9 LB</p> <p>SPRING RATE (REF) _____</p> <p>MANUFACTURE IN ACCORDANCE WITH</p> <p>MIL-S-13572, TYPE I, GRADE A.</p>								
<p>MECHANICAL PROPERTIES</p> <p>YP _____</p> <p>TS _____</p> <p>EL 2 _____</p> <p>RA _____</p> <p>BH _____</p> <p>RH _____</p>		<p>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES</p> <p>TOLERANCES ON DECIMALS</p> <p>ANGLES ± _____ .XX ± _____</p> <p>MATERIAL _____ XXX ± _____</p> <p style="text-align: center;">SEE NOTE</p> <p>HEAT TREATMENT _____</p> <p>FINAL PROTECTIVE FINISH _____</p> <p style="text-align: center;">NONE</p>		<p>ORIGINAL DATE OF DRAWING <b>AUG 15, 1942</b></p> <p>DRAFTSMAN <b>E C P</b> CHECKER <b>MEK</b></p> <p>THROU <b>WCH</b> CHECKER _____</p> <p>ENGINEER _____</p> <p>SUBMITTED _____</p> <p style="text-align: center;">E. M. HOPKINS</p> <p>APPROVED _____</p> <p style="text-align: center;">WALTER F. GORTON</p>		<p style="text-align: center;">DEPT OF THE ARMY</p> <p style="text-align: center;">ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201</p> <p style="text-align: center; font-size: 1.2em;">SPRING, HELICAL</p> <p>DWG SIZE <b>B</b> CODE IDENT NO. <b>19204</b> <b>5153128</b></p> <p>SCALE _____ UNIT WT _____ SHEET _____ OF _____</p>		

SWER1 FORM 40B. 1 MAR 67

5

4

3

2

1

## NOTES:

1. MATERIAL:  
WIRE, MUSIC, SPEC QQ-W-470.
2. HEAT TREATMENT:  
STRESS RELIEVE AT  $450^{\circ} \pm 25^{\circ} \text{F}$   
FOR 30 MINUTES AFTER FORMING.
3. FINAL PROTECTIVE FINISH:  
LUBRICATING OIL, SPEC VV-L-800.
4. SPRING FUNCTIONS IN HOLE .373 MIN.
5. SPRING FUNCTIONS OVER ROD .190 MAX.

OUTSIDE DIA SOLID, NOT MORE THAN \_\_\_\_\_ .370  
 INSIDE DIA FREE, NOT LESS THAN \_\_\_\_\_ .275  
 ASSEMBLED HEIGHT BASIC \_\_\_\_\_ .310  
 LOAD AT ASSEMBLED HEIGHT \_\_\_\_\_  $4.5 \pm 0.5 \text{ LBS}$   
 SOLID HEIGHT, NOT MORE THAN \_\_\_\_\_ .178  
 DIA OF WIRE (APPROX) \_\_\_\_\_ .035  
 FREE HEIGHT (APPROX) \_\_\_\_\_ .440  
 NUMBER OF COILS (APPROX) \_\_\_\_\_ 4  
 DIRECTION OF COILING \_\_\_\_\_ L.H.  
 ENDS CLOSED  
 OPERATING HEIGHT BASIC \_\_\_\_\_ .180  
 LOAD AT OPERATING HEIGHT \_\_\_\_\_  $9.0 \pm 1.0 \text{ LBS}$   
 SPRING RATE (REF) \_\_\_\_\_  
 MANUFACTURE IN ACCORDANCE WITH MIL-S-13572, TYPE I, GRADE B.

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	REDRAWN AND REVISED W/CHG SEE EO RIA-14488	25 JAN 68

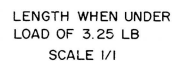
PART NO. 5153130

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 15 AUG 1942		DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND. ILL. 61201	
YP		TOLERANCES ON	DECIMALS XX ±	DRAFTSMAN R.S.	CHECKER M.E.K.	SPRING, MAGAZINE CATCH	
TS		ANGLES ±	XXX ±	TRACER T. Ring	CHECKER E.K.		
EL 2		MATERIAL	SEE NOTE 1	ENGINEER E.C.P.	ENGINEER E.J.A.		
RA	F6535469	.30 B.A.R.	HEAT TREATMENT	SUBMITTER Philip G. Hebert		DWG SIZE B	CODE IDENT NO. 19204
BH		M1918A2	SEE NOTE 2	APPROVED R. J. Henry		5153130	
RH		APPLICATION	FINAL PROTECTIVE FINISH SEE NOTE 3			SCALE	UNIT WT
		NEXT ASSY.	USED ON			SHEET	OF

SWRI FORM 40B. 1 MAR 67

[illegible]

A



SWESP 1178-1  
28 AUG 62

---

PDC



4

3

2

1

## 1. NOTES:

FINISH  $\frac{125}{Y}$  EXCEPT STAMPED OR SHEARED  
EDGES  $\frac{250}{Y}$ .

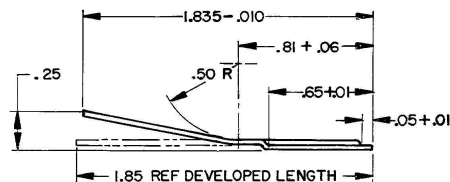
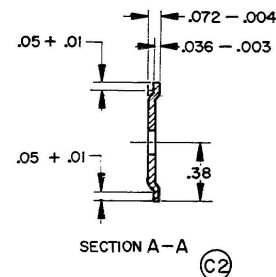
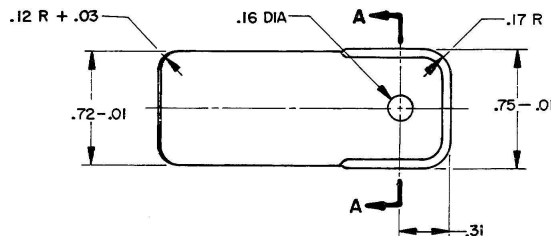
2. BREAK EDGES .01 MAX.

3. MATERIAL: STEEL, COMP 1095, SPEC QQ-S-777.

4. HEAT TREATMENT: HEAT AT 1450°F TO 1500°F. OIL QUENCH. TEMPER 1/2 HR AT 650°F TO HARDNESS SPECIFIED.

HEAT TREATMENT METHOD IS FOR GUIDANCE ONLY EXCEPT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.

5. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171, EXCEPT PARA 3.3 OF MIL-P-16232 SHALL NOT APPLY. (C1)



REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED
	REPLACES REV A W/CHANGE	3 NOV 67	P. Heberle
	SEE EO RIA-14469		
C	(1-3) SEE EO HRD 92047	7 APR 69	R. Henry

C5564906		BMG, CAL 30		PART NO. 7266108	
MECHANICAL PROPERTIES		MIS9A4(FLEX)		DEPT OF THE ARMY	
YP		MIS9A4(FXD)		ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
TS		MIS9A6		<b>SPRING, REAR SIGHT BASE</b>	
EL 2		F7142946 GUN, MACH,			
RA		CAL 30, M37		DWG SIZE CODE IDENT NO.	
BH		SEE ENGINEERING RECORDS		C 19204 7266108	
RH A 73-76		NEXT ASSY USED ON		SCALE 2/1 UNIT WT .01 SHEET 1 OF 1	
APPLICATION		HEAT TREATMENT			
APPLY PART NO.		SEE NOTE 4			
		FINAL PROTECTIVE FINISH			
		SEE NOTE 5			

4

3

2

1

## NOTES:

1. FINISH  $\checkmark$  125/ ALL OVER.

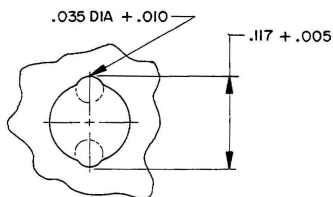
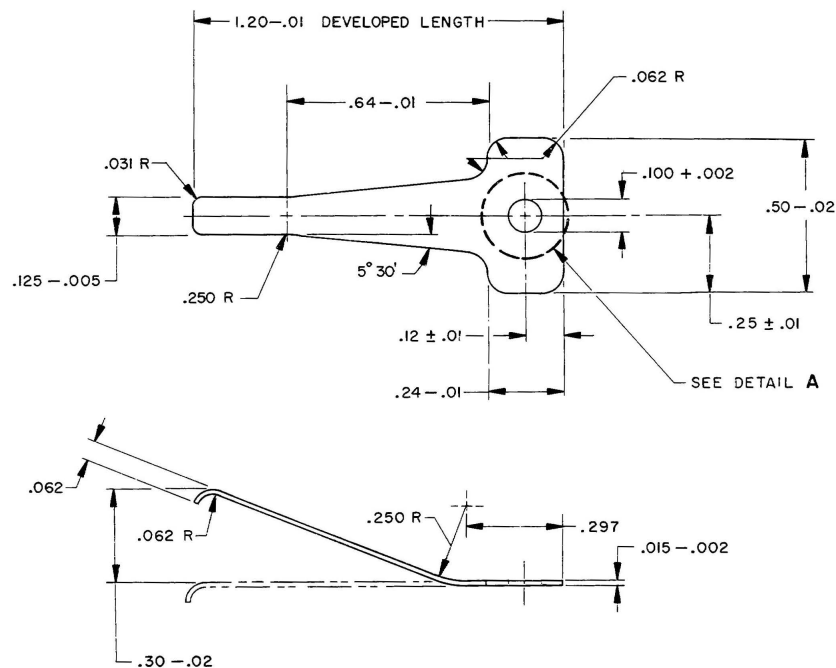
## 2. MATERIAL:

STEEL, COMP 1055 OR 1065, SPEC QQ-S-777.

## 3. HEAT TREATMENT:

HEAT AT 1500° TO 1550° F FOR 3 TO 5  
MINUTES. OIL QUENCH. TEMPER 45 MINUTES  
TO HARDNESS SPECIFIED. HEAT TREATMENT  
METHOD IS FOR GUIDANCE ONLY EXCEPT  
TEMPERING TIME SHALL NOT BE REDUCED  
BELOW THAT SPECIFIED.

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	REDRAWN & REVISED W/CHANGE SEE EO RIA-14488	25 JAN 68	<i>Kerodling</i>

DETAIL A  
SCALE 10/1

PART NO. 6147489

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 5 JUN 1940		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON DECIMALS XX ± XXX ± .015		DRAFTSMAN W. L. M.	CHECKER C. H. C.	SPRING, STOP LEVER	
TS		ANGLES ±1° MATERIAL		TRACER <i>R. P. [signature]</i>	CHECKER <i>[signature]</i>		
EL 2		SEE NOTE 2		ENGINEER C. J. T.	ENGINEER J. A.		
RA		HEAT TREATMENT		SUBMITTED <i>Philip E. [signature]</i>			
BH	C6147490	.30 B.A.R.	SEE NOTE 3	APPROVED <i>R. S. [signature]</i>		DWG SIZE C	CODE IDENT NO. 19204
RH	15N 64-86.5	NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH		SCALE 4/1	UNIT WT
APPLICATION						SHEET 1	OF 1

C6147489

1. SPEC MIL-W-13855 APPLIES.
2. MATERIAL: STEEL CARBON 1095, ASTM A568.
3. HEAT TREATMENT: HEAT TO 1425°F. 1450°F IN SALT 5 MIN. QUENCH IN OIL. TEMPER AT 700°F FOR 15 MIN.
4. FINAL FINISH: PROT. FINISH: AT ASSEMBLY.
5. DO NOT INSCRIBE PART NO.

TOLERANCE  $\pm .01$  ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.  
SUPERSEDES OLD TRACING B19659 UNDER REVISION DATE OF JUNE 1, 1936

CURRENT DESIGN ACTIVITY CAGE CODE 19200  
U.S. ARMY  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PART NO. 6019659

SPRINGFIELD ARMORY  
SPRINGFIELD, MA

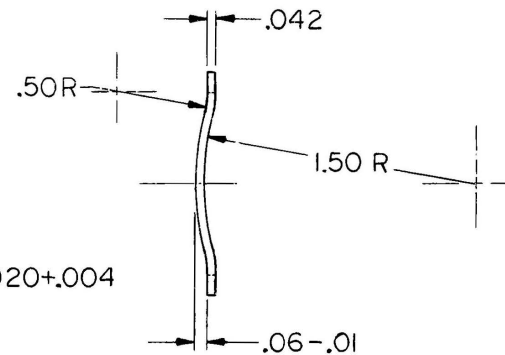
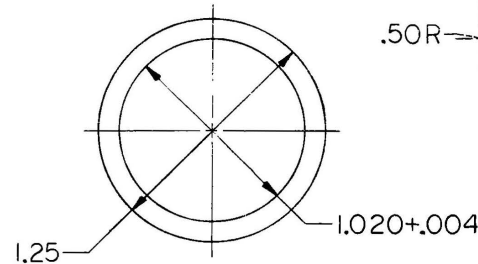
SPRING, TRIGGER GUARD,  
RETAINING PIN

SMCAR FORM 67, 1 JUN 86(TEMP) REPLACES SMCAR FORM 67, 1 FEB 85.  
WHICH MAY BE USED UNTIL EXHAUSTED



NOTES:

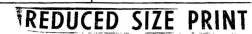
1. STEEL, GRADE 1095, ASTM A684 OR AMS 5121.
2. FINISH  $125/\sqrt{\text{ALL OVER.}}$
3. HEAT AT 1425°F THRU 1450°F. OIL QUENCH, TEMPER AT 700°F THRU 750°F.
4. MIL-W-13855 APPLIES.



REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	REPLACES REV 3 W/CHANGE SEE ERR HQR 50626	18 MAR 75

PART NO. 5152771

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 JUN 39		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YS MIN		TOLERANCES ON	DECIMALS .XX ±.01	DRAFTSMAN	CHECKER	SPRING, WASHER	
YS MAX		ANGLES ±	XXX ±.005	TRACER	CHECKER		
EL 2		MATERIAL	SEE NOTE 1	ENGINEER	ENGINEER		
RA		RIFLE: CAL 30	HEAT TREATMENT	SUBMITTED		DWG SIZE	CODE IDENT NO.
BH		C 6147333 M1918 A2	SEE NOTE 3	DONALD S. BUTTERWORTH		B	19204
RH	C42-47	APPLICATION	FINAL PROTECTIVE FINISH	APPROVED		SCALE 2/1	UNIT WT
				D. D. Cole		SHEET 1	OF 1

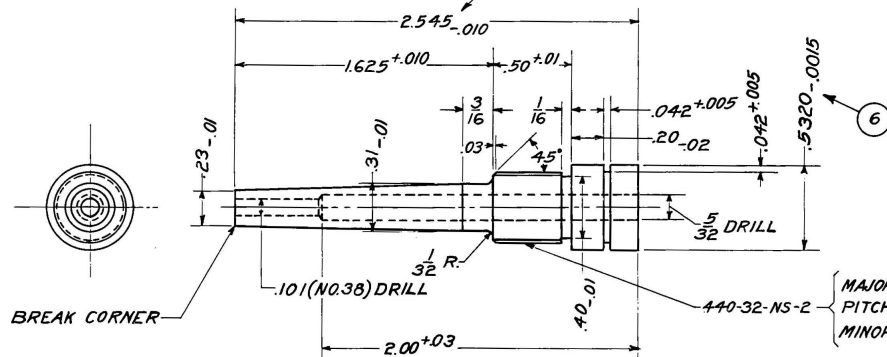


# HEAT TREATMENT & FINAL FINISH

PROT. FINISH: AT ASSEMBLY

8

FINISH LENGTH  
AFTER ASSEMBLY



## PHYSICAL PROPERTIES

JUNE 5, 1940

REVISION

Y.P.	11-22-40	7-28-45
T.S.	4-28-41	8-19 AUG 55
EL. 2	4-25-42	
RED.	12-14-42	
BR.	3-1-43	
ROCK.	3-1-45	
SCL.		

DRG. PERTAINS TO

51-10230 BAR-M1918-A2

661230 SLEEVE, STOCK

6564230 RETAINING, ASM.

STOP, ACTUATOR B147481-6 6147484

STEEL, FED SPEC QQ-S-633-FS1022 OR FS B1112

FINISH ALL OVER 125

MANUFACTURING COMPONENT

NOTE - ALTERNATIVE DESIGN.

THE .042 X .042 BRAZING WIRE

GROOVE ELIMINATED. 1/32 X 45°

CHAMFER AT OUTSIDE END OF LARGE

DIAMETER, OTHERWISE SAME AS

STANDARD.

TOLERANCE ±.01 ALLOWED ON ALL DIMEN-  
SIONS UNLESS OTHERWISE SPECIFIED.

8

DWG B7266102 APPLIES

SCALE 2/7

B6147484

B-147484

SUPERSEDES B147484

B6147484

## SYMBOL

DO NOT INSCRIBE PART NO.

OFFICIAN TRACER U.S. DEPT. OF THE ARMY

CHECKER U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

U.S. DEPT. OF THE ARMY

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				MAY 1, 1929	
		Y.P.		RED.		ROCK	
		T.S.		BR.			
		EL.2					
TYPE I OR II SPEC MIL-C-16232  		DO NOT INSCRIBE PART NO.  10 11		REVISIONS 8 2-3-44 9 5-22-44 10 CONVERSION 1-28-49 11 19 AUG 55		DR'G. PERTAINS TO 5113 30BAR M18 51102 30B.ARM1918A2 819697 SPRING CHANGE LEVER STOP ASSEMBLY 86019697	
STOP, CHANGE LEVER STEEL, FED SPEC QQ-S-633 FS1117 FINISH ALL OVER		A22207-9 5022207 SCALE 4/1 DWG B7266102 APPLIES SPRINGFIELD ARMORY A5022207 A22207		DFTSMAN TRACER L'DG. DFTSMAN CHECKER SUBMITTED:		APPROVED BY ORDER OF THE CHIEF OF ORDNANCE LT COL ORD. DEPT. ORDNANCE DEPT., U. S. A.	

TOLERANCE ±.01 ALLOWANCE ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.  
 SUPERSEDES OLD TRACING A22207 UNDER REVISION DATE OF FEBRUARY 3, 1944

5		4		3		2		1			
<b>NOTES:</b> 1. FINISH ALL OVER $\sqrt{25}$ . 2. ALL EDGES SHALL BE BROKEN $.003 \pm .012$ UNLESS OTHERWISE SPECIFIED. 3. MATERIAL: STEEL, COMP 1020, SPEC QQ-S-634.						REVISIONS					
						LTR	DESCRIPTION	DATE	APPROVED		
						A	REDRAWN & REVISED W/CHANGE SEE EO RIA - 14488	25 JAN 68	<i>Kawelins</i>		
						PART NO. 5152888					
						DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201					
MECHANICAL PROPERTIES		C6147499 30 B.A.R. MI918A2 SEE ENGINEERING RECORDS NEXT ASSY USED ON APPLICATION APPLY PART NO.		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS $\pm .015$ FRACTIONS $\pm$ ANGLES $\pm$ MATERIAL SEE NOTE 3 HEAT TREATMENT FINAL PROTECTIVE FINISH		ORIGINAL DATE OF DRAWING 5 JUN 1940 DRAFTSMAN H. J. O. TRACER <i>Boise</i> ENGINEER <i>Van Zenberg</i> SUBMITTED <i>C. J. T.</i> APPROVED <i>Phil E. Heberle</i> <i>R. J. Henry</i>		CHECKER C. H. C. CHECKER <i>Elk</i> ENGINEER E. J. A.		<b>STOP, CONNECTOR</b>	
YP											
TS											
EL 2											
RA											
BH											
RH											
DWG SIZE B CODE IDENT NO. 19204		5152888		SCALE 10/1 UNIT WT SHEET 1 OF 1							

EWSP FORM NO. 1176-3  
20 MAR 64 REV.

4

3

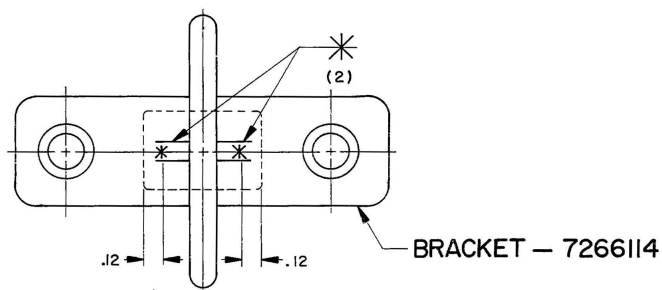
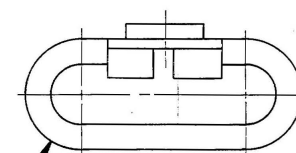
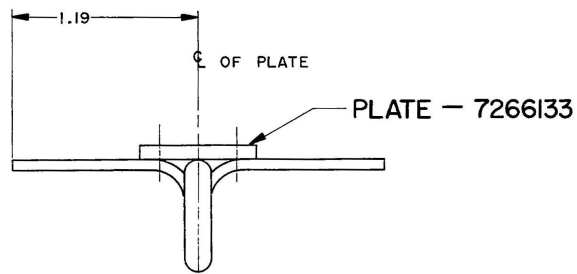
2

1

## NOTES:

1. WELD IN ACCORDANCE WITH MIL-W-12332.
2. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	REDRAWN & REVISED W/CHANGE. SEE EO RIA-14533	18, DEC 1967	<i>W. Ash</i>



FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7266132

PART NO. 7266132

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 15 OCT 51		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON DECIMALS XX ± .01		DRAFTSMAN R. H. S.	CHECKER D. H.	SWIVEL, BUTT, ASSEMBLY	
TS		ANGLES ± XXX ±		TRACER <i>C.R. Rupp</i>	CHECKER <i>Kenneth Ash</i>		
EL 2		MATERIAL		ENGINEER	ENGINEER R.W.M.		
RA		HEAT TREATMENT		SUBMITTED <i>Philip E. Heberle</i>			
BH	F7265703	.30 BAR		APPROVED <i>R. S. Henry</i>		DWG SIZE C	CODE IDENT NO. 19204
RH		M18A2				7266132	
		NEXT ASSY. USED ON				SCALE 2 / 1	UNIT WT
		APPLICATION		SEE NOTE 2		SHEET 1 OF 1	

5

4

3

2

1

## NOTE :

## 1. MATERIAL :

STEEL, COMP 1010, 1020, SPEC QQ-S-631

OR SPEC QQ-S-634

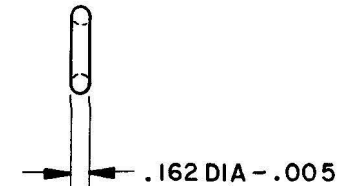
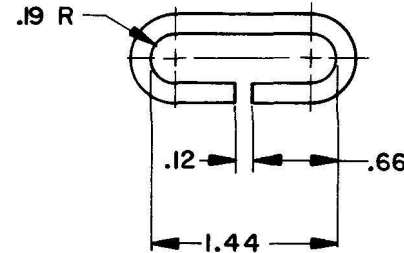
OR

STEEL, COMP 1117, SPEC QQ-S-637.

## 2. LENGTH BEFORE BENDING = 3.69 REF.

## REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	REDRAWN & REVISED W/CHANGE SEE EO RIA- 14533	18, DEC 1967	<i>W. Ash</i>



PART NO. 5130036

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 15 MAR 35		DEPT OF THE ARMY	
YP				TOLERANCES ON DECIMALS .XX ± .01		DRAFTSMAN A. M. S.		CHECKER A. J. L.	
TS				ANGLES ± .XXX ±		TRACER <i>R. Randolph</i>		CHECKER <i>Wm. Ash</i>	
EL 2				MATERIAL SEE NOTE 1		ENGINEER J. J. B.		ENGINEER A. J. A.	
RA		.30 B A R		HEAT TREATMENT		SUBMITTED <i>Philip E. Heberle</i>		DWG SIZE B	
BH		C7266132		FINAL PROTECTIVE FINISH AT ASSEMBLY		APPROVED <i>R. S. Henry</i>		CODE IDENT NO. 19204	
RH		M I 8 A 2						SHEET 1 OF 1	
		NEXT ASSY.		USED ON				UNIT WT	
		APPLICATION						SCALE 1 / 1	

SWIVEL, BUTT

5130036

HEAT TREATMENT & FINAL FINISH

BRACKET-5022213

SWIVEL-6008890

SCREW-5022244

SWIVEL, FRONT ASSEMBLY (5564073)

LIST OF COMPONENTS			
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	QUANTITY REQUIRED
1	064073	SWIVEL, FRONT ASSEMBLY	(1)
2		COMPOSED OF	
3	A 22213	BRACKET, FRONT SWIVEL	
4			
5	A 22244	1 SCREW, BRACKET SWIVEL	
6	A 22210	1 SWIVEL, BRACKET	

\*WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES  
SUPERSEDES OLD TRACING B19683 UNDER REVISION DATE OF JUNE 1, 1936.

NOTES: THIS DRAWING SHALL NOT BE USED OR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT

0 1 2 3 4 5 INCHES.

PHYSICAL PROPERTIES		JUNE 1, 1936	
		REVISIONS	
Y.P.	1	11-15-37	
T.S.	2	6-7-39	
EL-2	3	12-1-43	
RED	4	2-12-44	
RT T	5	4-15-46	
BR.	6	2-22-50	
	7	1-16-50	
SCL	8	9-7-50	
CC.	9	9 JUNE 55	
		15 AUG 66	
		15 OCT 68	
		DRG PERTAINS TO	
		5-13-100-242 MAG	
		7280705 30 BAR M1918A2	

DO NOT INSCRIBE PART NO

SYMBOL

AJS 13

OF ISHAN TRACER (MILITARY) (MILITARY)

ORIGIN

DATE

APPROVED BY (OFFICE OF THE CHIEF OF ORDNANCE)

LT COL. ORD. DEPT. USA

ORDNANCE DEPT. USA

C5564073  
C-64073

SUPERSEDES C64073

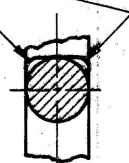


NOTICE—WHEN GOVERNMENT DRAWING SPECIFICATIONS OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH THEY WERE ORIGINALLY INTENDED, THE USER INCURS NO RESPONSIBILITY TO THE GOVERNMENT FOR ANY INADEQUACIES OR DEFICIENCIES IN THE DRAWING SPECIFICATIONS OR OTHER DATA. THE GOVERNMENT WILL NOT BE HELD RESPONSIBLE FOR ANY INADEQUACIES OR DEFICIENCIES IN THE DRAWING SPECIFICATIONS OR OTHER DATA. THE GOVERNMENT WILL NOT BE HELD RESPONSIBLE FOR ANY INADEQUACIES OR DEFICIENCIES IN THE DRAWING SPECIFICATIONS OR OTHER DATA.

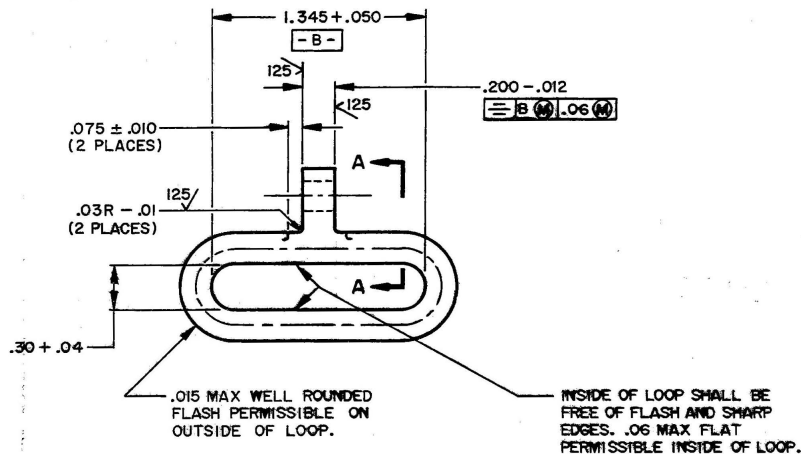
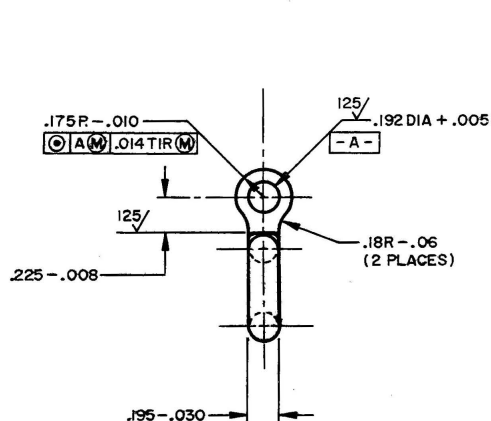
# NOTES:

1. FINISH 250/ EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .01+ .02 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL: STEEL, CARBON: C (H1) SAE 1018 THRU 1022, 1141; ASTM A108
4. MIL-W-13855 APPLIES.

.005R+.045



PARTIAL SECTION AA  
SCALE: 4/1



REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
F		5 MAY 60	
G	REDRAWN AND REVISED SEE EO SA 27411	16 MAR 64	
H	(1) SEE EO SA 29263	18 MAY 66	
J	(1) SEE EO SA 29615	23 AUG 66	
K	SEE ERR HQ 40683	12 NOV 74	
L	NOR W452051/840824	860121 MR	

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 6008890

C5564073 - 30BAR-M198A2		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 2 AUG 37		SPRINGFIELD ARMY U.S. ARMY WEAPONS COMMAND	
MECHANICAL PROPERTIES	B11010044 RIFLE, M14A1	TOLERANCES ON DECIMALS ±		DRAFTSMAN	CHECKER	SPRINGFIELD 1, MASS. U.S. ARMY MATERIEL COMMAND	
YP	D6535467 .30R-M1, MIC	FRACTIONS ±		TRACER	CHECKER	SWIVEL, SLING	
TS	& MID	ANGLES ±		WHS	DSK		
EL 2	SEE ENGINEERING RECORDS	MATERIAL		ENGINEER	ENGINEER		
RA	NEXT ASSY USED ON	HEAT TREATMENT		SUBMITTER	APPROVED		
BH	APPLICATION	FINAL PROTECTIVE FINISH		K.S. Henry		CODE IDENT NO. DWG SIZE	
RH	DO NOT APPLY PART NO	FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171		J. J. Lunkin		19205 C	6008890
SCALE 2/1		UNIT WT. .03		SHEET 1 OF 1			

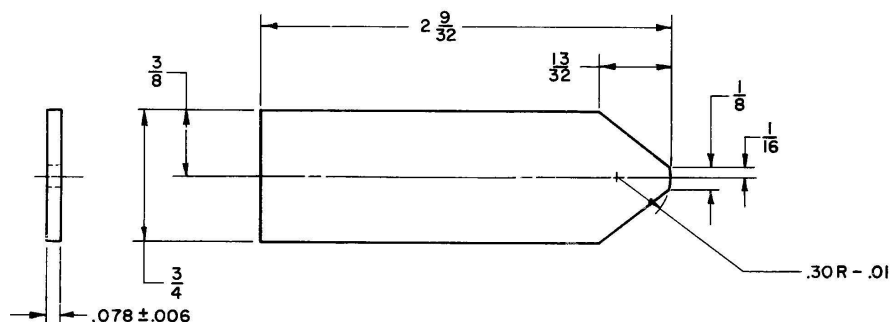
06 FORM 1176  
1 APR 54

NOTICE: When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility nor any obligation whatsoever; and the fact that the Government may have formulated, furnished, or in any way controlled the said drawings, specifications or other data is not to be regarded by implication or otherwise as in any manner trusting the holder or any other person or corporation, or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.

5153155

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
4		12 APR 56	
A	REDRAWN AND REVISED WAS 'A' SIZE	19 DEC 55	<i>R. S. Henry</i>
B	(1-3) SEE EO RIA-14469	3 NOV 63	<i>R. S. Henry</i>

1. STEEL, CR STRIP, TEMPER NO. 3, SPEC QQ-S-698.
2. FINISH  $125\sqrt{\text{EXCEPT STAMPED OR SHEARED EDGES } 250\sqrt{\text{B3}}$
3. BREAK EDGES .005 R MAX.



B2

CODE IDENT NO. 19204  
PART NO. 5153155

B1

D7265564 .30 BAR M1918A2		PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS DECIMALS ANGLES $\pm 1/64$		ORIGINAL DATE OF DRAWING 6 NOV 42		TONGUE, REAR SIGHT BASE BODY		DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 61201	
SEE ENGINEERING RECORDS		MATERIAL SEE NOTE 1		HEAT TREATMENT		DRAFTSMAN FCL CHECKER <i>R. S. Henry</i> TRACER <i>R. S. Henry</i> CHECKER <i>R. S. Henry</i> ENGR <i>R. S. Henry</i> ENGR <i>R. S. Henry</i>					
NEXT ASSY		USED ON		FINAL PROTECTIVE FINISH APPLIED AFTER ASSEMBLY		APPROVED BY CHIEF OF THE CHIEF OF DRAWING <i>R. S. Henry</i> AND CORPS <i>R. S. Henry</i>		SCALE 2 / 1		UNIT WT .03	
DO NOT 99-		APPLY PART NO. AS SPECIFIED						DWO SIZE B		5153155 SHEET 1 OF 1	

4

3

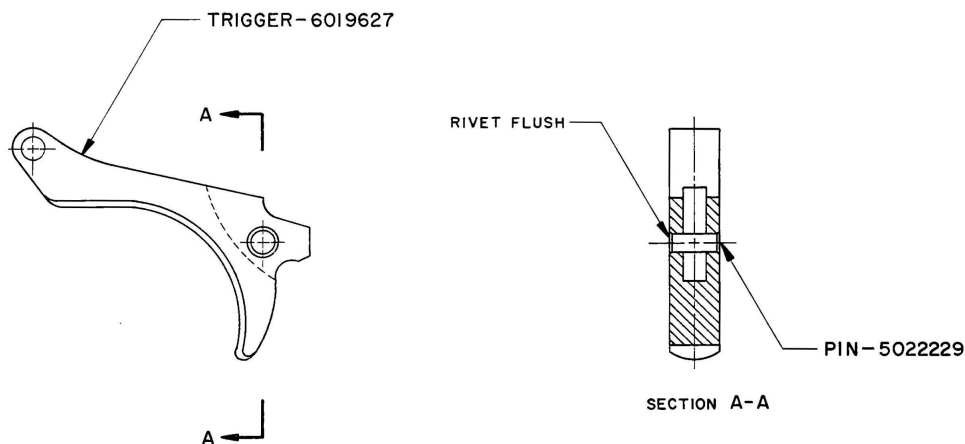
2

1

## NOTE:

1. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2 OF  
MIL-STD-171.

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	REDRAWN & REVISE SEE EO R1A-14488	25 JAN 68



FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 6019684

PART NO. 6019684

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 MAY 1929		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON	DECIMALS .XX ±	DRAFTSMAN	F.L.V.	CHECKED	L.S.C.
TS		ANGLES ±	.XXX ±	TRACER	<i>John A. Pauling</i>	CHECKED	<i>Elmer</i>
EL 2		MATERIAL		ENGINEER	E.J.A.	ENGINEER	L.S.C.
RA		HEAT TREATMENT		SUBMITTED	<i>Philip E. Hulse</i>		
BH	F6535469	.30 B.A.R.		APPROVED	<i>K. S. Henry</i>		
RH		M1918A2					
	NEXT ASSY.	USED ON	FINAL PROTECTIVE FINISH				
	APPLICATION		SEE NOTE 1				
					DWG SIZE	CODE IDENT NO	
					C	19204	6019684
					SCALE 2/1	UNIT WT	SHEET 1 OF 1

8

7

6

5

4

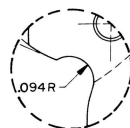
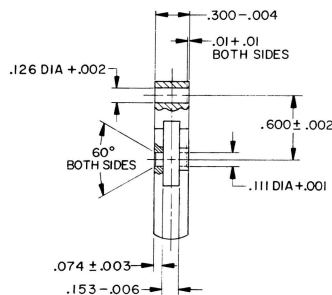
3

2

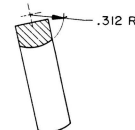
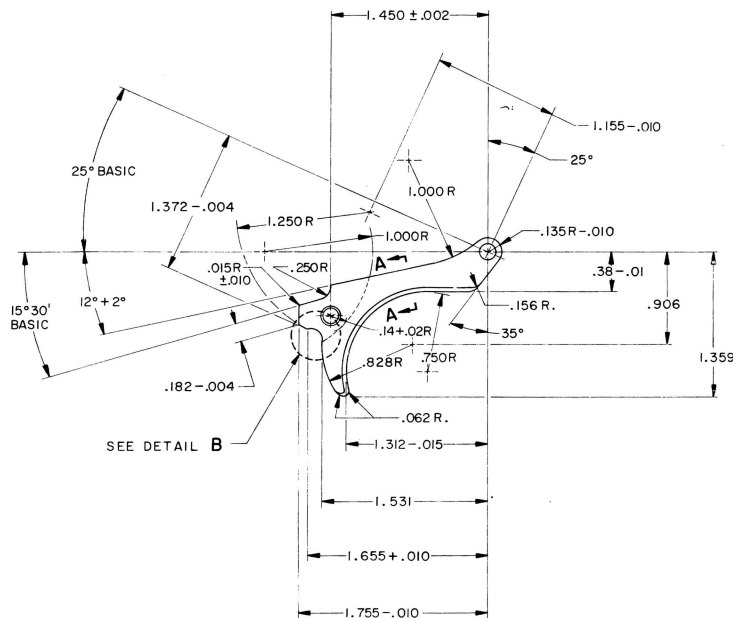
1

## NOTES:

1. FINISH ALL OVER  $\sqrt{125}$ .
2. ALL EDGES SHALL BE BROKEN .003 + .012 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL:
  - A. FOR WROUGHT MATERIAL: STEEL, COMP 1020, SPEC QQ-S-634.
  - B. FOR PRECISION CASTING: STEEL, COMP 108620, MIL-S-22141, EXCEPT CARBON .08-.18 PERCENT. TENSILE STRENGTH SHALL NOT APPLY.
4. HEAT TREATMENT: CARBURIZE AT  $1600 \pm 25^\circ \text{F}$  TO CASE DEPTH .004-.008. TEMPER AT  $350^\circ \text{F}$  FOR 30 MINUTES. HEAT TREATMENT METHOD IS FOR GUIDANCE ONLY EXCEPT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. INSPECTION SHALL BE IN ACCORDANCE WITH MIL-C-6021, CLASS 1B, GRADE A.
6. FILEHARD TEST IN ACCORDANCE WITH SA-STD-104.



DETAIL-B  
SCALE 5/1



SECTION A-A

PART NO. 6019627

DEPT OF THE ARMY  
ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201

TRIGGER

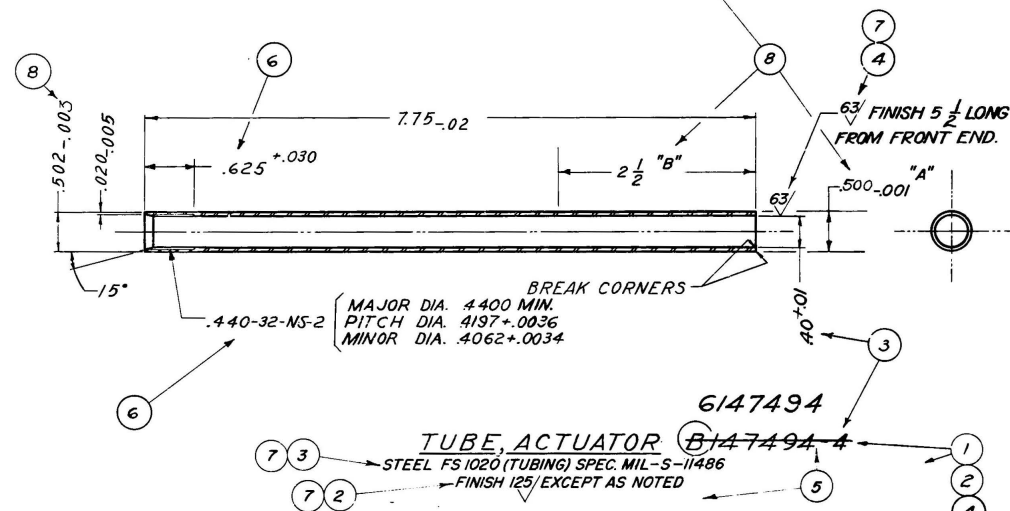
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 MAY 1929		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON DECIMALS XXX ± .015		DESIGNED BY F.C.L.	CHECKED F.B.	DWG SIZE CODE IDENT NO. 6019627 SCALE 2/1 UNIT WT SHEET 1 OF 1	
TS		ANGLES & 1°		BY D. H. C. H. C.	CHECKED E.H.		
EL S		SEE NOTE 3		DESIGNED BY D. H. C. H. C.	ENGINEER T.J.W.		
RA		HEAT TREATMENT		SUBMITTED			
BH	C6019684	30 B.A.R.	SEE NOTE 4	APPROVED Philip E. H. H.			
FILEHARD	M1918 A2	FINAL PROTECTIVE FINISH		APPROVED R. S. Henry			
APPLICATION		AT ASSEMBLY					

NOTES: THIS DRAWING SHALL NOT BE USED OR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT AS AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

# HEAT TREATMENT & FINAL FINISH

AT ASSEMBLY

NOTE: DIA "A" TO APPLY FOR LENGTH "B"



6147494  
TUBE, ACTUATOR  
STEEL FS 1020 (TUBING) SPEC. MIL-S-11486  
FINISH 125/ EXCEPT AS NOTED

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

DWG. B7266102 APPLIES

SCALE 1/1

## PHYSICAL PROPERTIES

Y.P.  
T.S.  
EL.2  
RED.  
BR.  
ROCK.  
SCL.

JUNE 5, 1940

## REVISIONS

1	2-5-42	7	12-12-51
2	4-25-42	8	8-28-52
3	11-9-43		
4	4-17-44		
5	8-28-48		
6	11-21-51		

## DRG. PERTAINS TO

51-192 30BAR-M1918-A2  
B147495 TUBE WITH CAPASIM  
B6147495

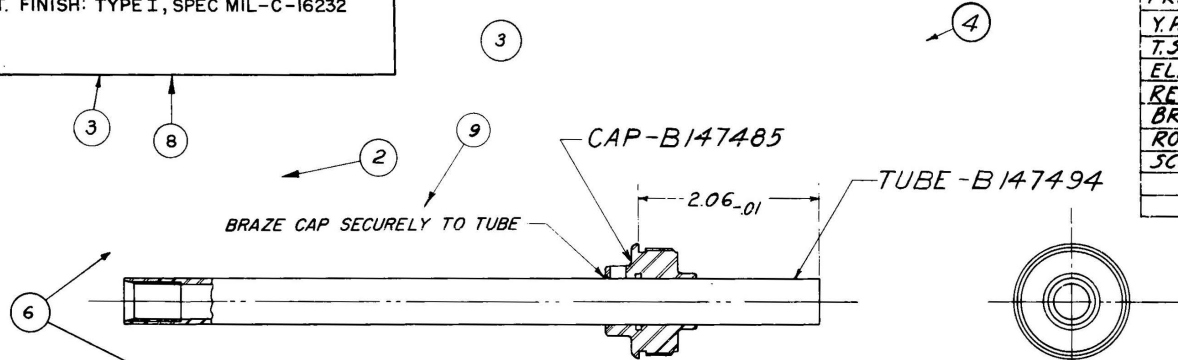
## SYMBOL

DO NOT INSCRIBE PART NO.  
OFFICER IN CHARGE  
CHECKED BY  
SUBMITTED BY  
MAJ. DRD DEPT. U.S.A.  
APPROVED BY MEMBER OF THE  
ORDNANCE  
LTCOL J. B. BROWN  
ORDNANCE DEPT. U.S.A.

B6147494  
B147494  
SUPERSEDES B147494

B6147494

HEAT TREATMENT & FINAL FINISH  
PROT. FINISH: TYPE I, SPEC MIL-C-16232



PHYSICAL  
PROPERTIES

Y.P.	10-16-41	7	9 JUNE 55
T.S.	4-25-42	8	19 AUG 55
EL.2	12-8-42	9	10 APR 56
RED.	3-1-43		
BR.	5-9-43		
ROCK.	6-11-21-51		
SCL.			

JUNE 5, 1940  
REVISIONS

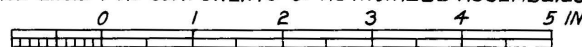
DRG. PERTAINS TO  
F7265703 30 BAR-M1918-A2

BRAZING MATERIAL:  
FOR COPPER BRAZING:- COPPER, ELECTROLYTIC  
(99.90% Cu & Ag) OR COPPER, DEOXYDIZED (99.90% Cu)  
FOR SILVER BRAZING:- SOLDER, SILVER, FED SPEC  
QQ-S-561: CLASS 0 OR 1

# LIST OF COMPONENTS

1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NO REQUIRED PER UNIT ASM
1	B147495	TUBE WITH CAP, ASSEMBLY	(1)
2		COMPOSED OF:-	
3	B147485	I-CAP, BUFFER TUBE	*
4	B147494	I-TUBE, ACTUATOR	*

\* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES  
TOLERANCE  $\pm .01$  ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.



NOTE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED WITHOUT WRITING OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

DWG B7266102 APPLIES

TUBE WITH CAP,  
ASSEMBLY

6147495

B147495-2

B6147495

B147495

SYMBOL

DO NOT INSCRIBE PART NO.

OFFICER IN CHARGE  
H.Q. 100  
CHECKER  
SUBMITTED  
MAJOR ORD. DEP. U.S.A.  
APPROVED BY ORDER OF THE  
CHIEF OF BUREAU  
ORDNANCE DEPT. U.S.A.

SUPERSEDES B147495

B6147495

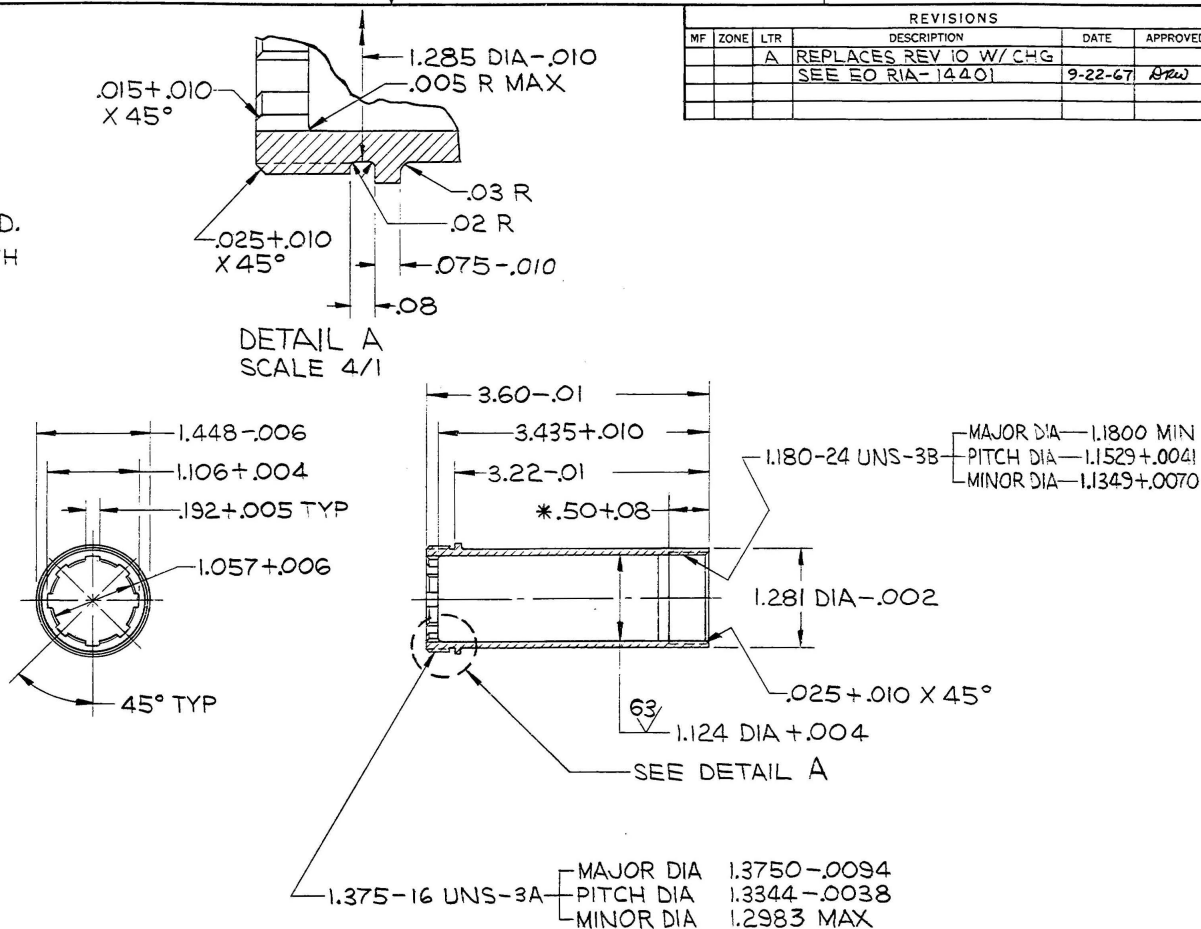
## NOTE:

1. STEEL, TUBING, SEAMLESS,  
COMP 1035, SPEC QQ-T-830  
OR  
STEEL, COMP 1035,  
SPEC QQ-S-631 OR  
SPEC QQ-S-634.

2. FINISH  $\frac{125}{\sqrt{\quad}}$  EXCEPT AS NOTED.

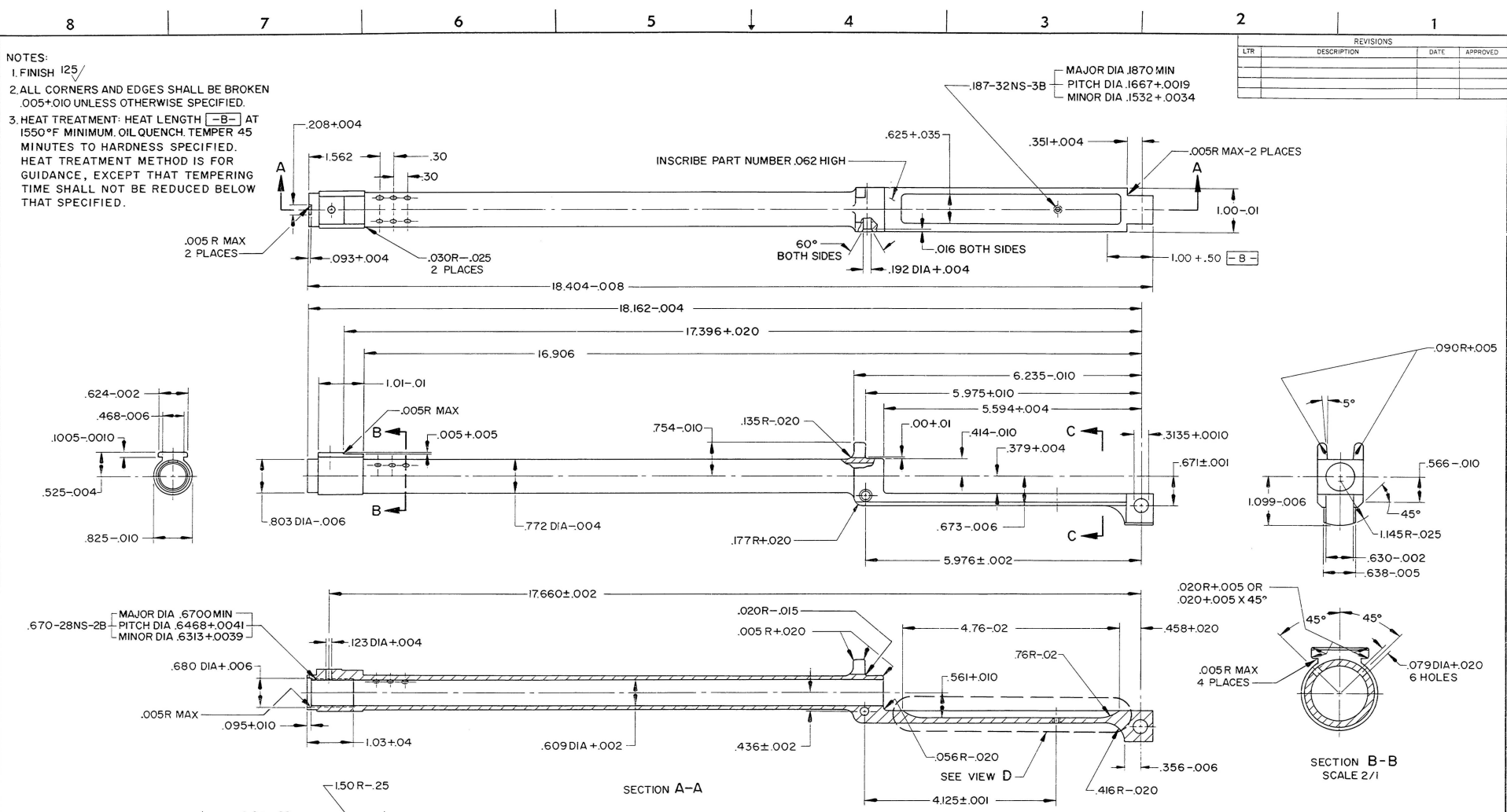
3. \* FULL THREAD FOR A LENGTH  
OF .500 MIN. RUNOUT OF  
THREAD WITHIN .50+.08  
DIMENSION. COUNTERBORE  
MINOR DIAMETER .590+.020  
DEEP.

4. FINISH 5.3.1.2 OF MIL-STD-171.



REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	REPLACES REV 10 W/ CHG	
			SEE EO RIA-14401	9-22-67
				APR

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING JUN 5, 1940		DEPT OF THE ARMY	
YP		TOLERANCES ON DECIMALS		DRAFTSMAN	WLM	CHECKER	CHC
TS		ANGLES ± 1°	XXX ±	TRACER	WLM	CHECKER	CHC
EL 2		MATERIAL	SEE NOTE 1	ENGINEER	WLM	CHECKER	CHC
RA		HEAT TREATMENT		ENGINEER	WLM	CHECKER	CHC
BH		NEXT ASSY.	USED ON	SUBMITTED		TUBE, BUFFER	
RH		APPLICATION	SEE NOTE 4	WILLEX GATON		DWG SIZE CODE IDENT NO.	
				APPROVED		C 19204 6147493	
				W. JAMES		SCALE 1/1 UNIT WT SHEET OF	



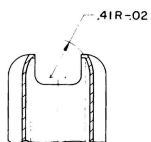
NOTES:  
 1. FINISH 125/  
 2. ALL CORNERS AND EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.  
 3. HEAT TREATMENT: HEAT LENGTH  $\boxed{-B-}$  AT 1550°F MINIMUM. OIL QUENCH. TEMPER 45 MINUTES TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.

REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED

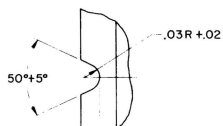
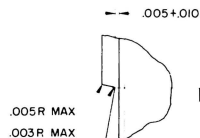
MECHANICAL PROPERTIES YP TS EL. 2 RA BH RH D57-66		.30 BAR F7265703 M1918A2 SEE ENGINEERING RECORDS NEXT ASSY USED ON APPLICATION APPLY PART NO. PER MIL-STD-130	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS ± DECIMALS ±.01 ANGLES ± MATERIAL: STEEL, FED. SPEC QQ-S-624: 4140 HEAT TREATMENT: SEE NOTE 3 FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171	ORIGINAL DATE OF DRAWING 7 NOV 66 DRAFTSMAN RJA CHECKER HW TRACER ENGINEER SUBMITTED APPROVED R. S. Henry	PART NO. 11010531 U. S. ARMY SPRINGFIELD ARMOY SPRINGFIELD, MASS. 01101 TUBE, GAS CYLINDER DWG SIZE CODE IDENT NO. D 19205 11010531 SCALE 1/1 UNIT WT SHEET 1 OF 1
---	--	---	---	---	---



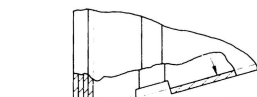
- NOTES
1. FINISH 125.
  2. ALL EDGES SHALL BE BROKEN .003+.007 UNLESS OTHERWISE SPECIFIED.
  3. AT THE TOP OF THE TUBE, ALL INTERIOR EDGES WITHIN THE AREAS OUTLINED ARE FUNCTIONALLY IMPORTANT AND SHALL BE FREE FROM BURRS, NICKS, OR OTHER MITIGATION AND SHALL BE BROKEN .005R+.005.
  4. MATERIAL: STEEL, FED. SPEC QQ-S-698: CARBON .24 PERCENT MAX, CR STRIP NO. 3 TEMPER.
  5. FINAL PROTECTIVE FINISH: FINISH 5.3.12 OR 5.3.2.2 OF MIL-STD-171. DO NOT ABRASIVE BLAST.



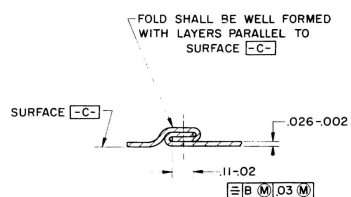
SECTION B-B



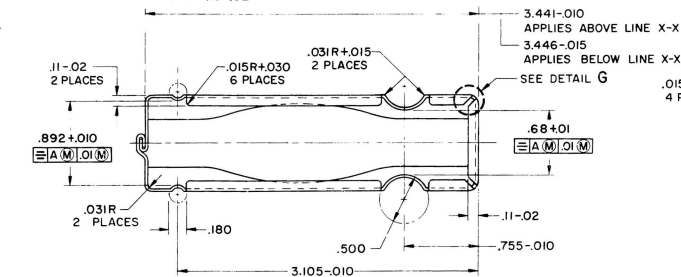
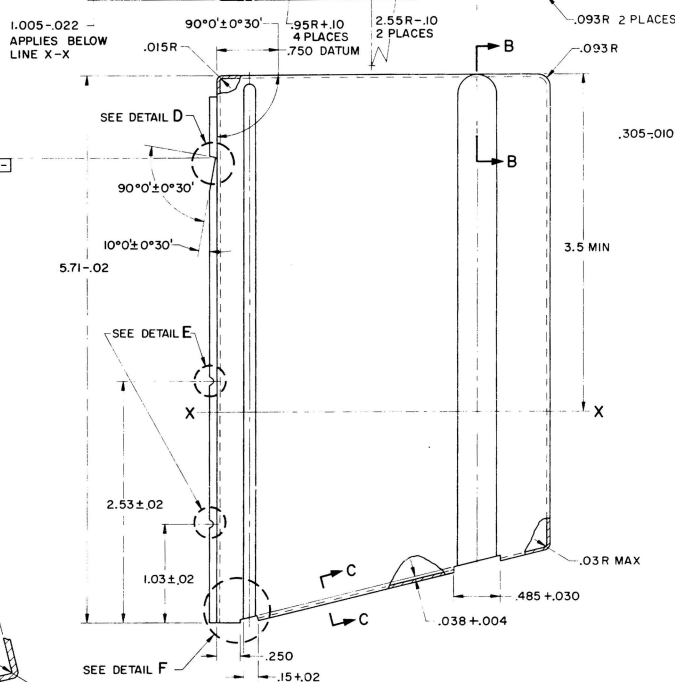
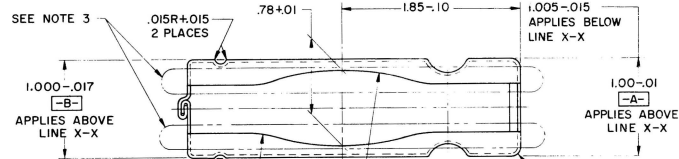
STAMP TO SECURE JOINT  
DETAIL E  
SCALE 10/1



DETAIL F  
SCALE 4/1



PARTIAL SECTION A-A  
SCALE 4/1



REV	DESCRIPTION	DATE	APPROVAL
14	REWORKED & REVISED, WAS "C" SIZE, 7 JANES	12 MAY 55	
A	REF. EO SA 27570		

PART NO. 5509078	
TUBE, MAGAZINE	
19205 F	5509078
19205 F	5509078

MECHANICAL PROPERTIES	UNLESS OTHERWISE SPECIFIED	ORIGINAL DATE OF DRAWING
YP	TOLERANCES ON DIMENSIONS ARE IN INCHES	1 MAY 29
TS	TOLERANCES ON DECIMALS ±.010	
EL 2	FRACTIONS ±	
RA	ANGLES ± 1°	
BH	MATERIAL:	
RH	SEE ENGINEERING RECORDS	
	HEAT TREATMENT	
	APPLICATION	
	DO NOT APPLY PART NO	
	FINAL PROTECTIVE FINISH:	
	SEE NOTE 5	

ORIGINAL DATE OF DRAWING	1 MAY 29
DRAWN BY	ELU
CHECKED BY	BME
TRACED BY	ELU
ENGINEER	ELU
DESIGNED BY	ELU
SUBMITTED	
APPROVED	

CODE IDENT NO	19205 F
UNIT WT	5509078
SHEET 1 OF 1	

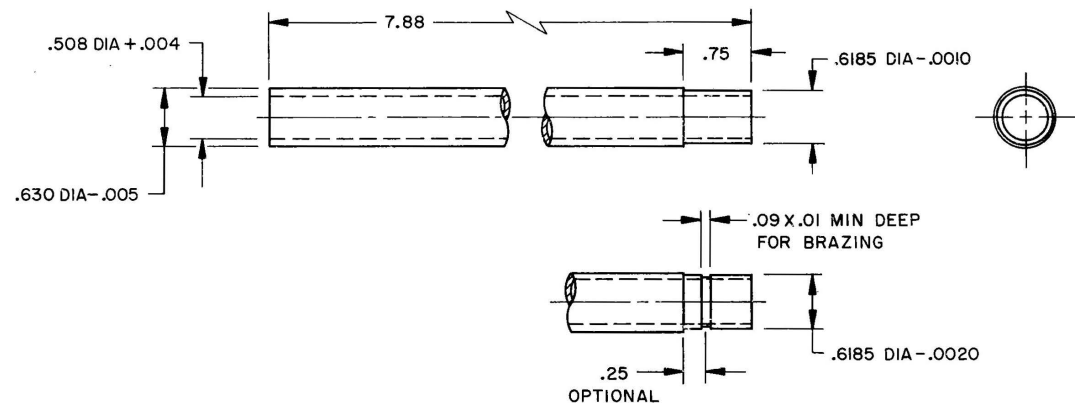
NOTE:

1. FINISH 125/.

2. MATERIAL:

STEEL, COMP 1020, SPEC QQ-T-830.

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	REDRAWN & REVISED W/CHG SEE EO 82075	8 APR 68	P. Heberle



PART NO. 5152775

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 JUNE 1939		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON	DECIMALS XX ± .01	DRAFTSMAN	EJR	CHECKER	LSC
TS		ANGLES ±	XXX ±	TRACER	W. A. Gaskill	CHECKER	P. Heberle
EL 2		MATERIAL	SEE NOTE 1	ENGINEER	P. Heberle	ENGINEER	P. Heberle
RA	C7312236	.30 BAR-M18A2	HEAT TREATMENT	SUBMITTED			
BH	B7312237	.30 BMG-M19A6	FINAL PROTECTIVE FINISH	APPROVED	Philip E. Heberle		
RH	APPLICATION			APPROVED	R. S. Henry		

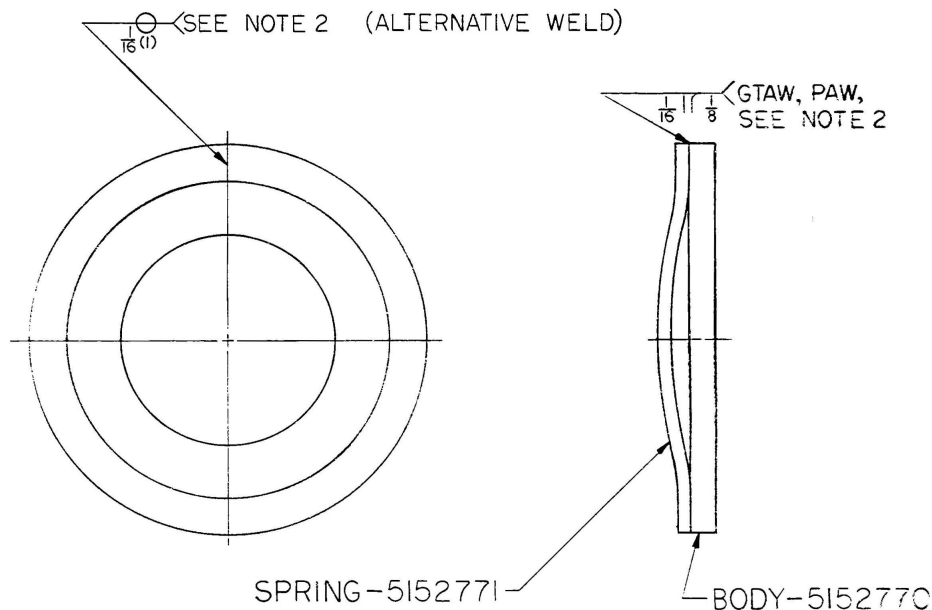
DWG SIZE	CODE IDENT NO.	
B	19204	5152775
SCALE 1/1	UNIT WT	SHEET 1 OF 1

SWERI FORM 40B. 1 MAR 67

# NOTES:

1. FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
2. ALTERNATIVE METHOD OF ASSEMBLY: BODY-5152770 AND SPRING-5152771 MAY BE HELD TOGETHER BY ADHESIVE MIL-A-81236 OR EQUAL. SHALL BE APPLIED AFTER FINAL PROTECTIVE FINISH.
3. STRENGTH OF WELD OR ADHESIVE SHALL BE STRONG ENOUGH TO HOLD ASSEMBLY TOGETHER DURING HANDLING. WELD TEMPERATURE AND AMOUNT OF ADHESIVE SHALL BE MINIMUM TO MEET THIS REQUIREMENT.
4. MIL-W-13855 APPLIES.

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	REPLACES REV 4 W/CHANGE	
			SEE ERR HQP 50625	19 MAR 55 <i>E. G. Smith</i>



SEE PL-6147333

PART NO. 6147333

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 JUN 39		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL 6121	
YP		TOLERANCES ON DECIMALS XX ±		DRAFTSMAN <i>D. Bourne</i>	CHECKER	WASHER ASSEMBLY.  FRICTION	
TS		ANGLES ±	XXX ±	TRACER	CHECKER		
EL 2		MATERIAL		ENGINEER <i>E. G. Smith</i>	ENGINEER		
RA		HEAT TREATMENT		SUBMITTED			
BH		RIFLE: CAL. 30		APPROVED <i>Donald S. Butterworth</i>		DWG SIZE C	CODE IDENT 19204
RH		F 7265703	M1918 A2	FINAL PROTECTIVE FINISH SEE NOTE 1		SCALE 4/1	UNIT WT
APPLICATION						6147333	



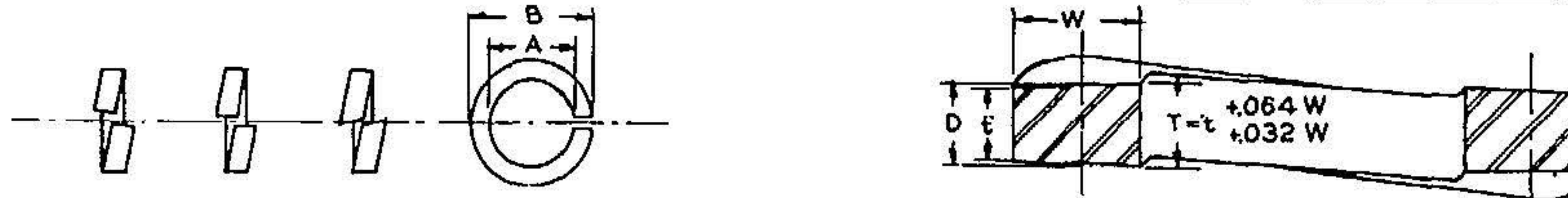
# WASHER, LOCK, SPRING LIGHT

## BEEX2

CODE IDENT 21450

ORDNANCE DEPARTMENT STANDARDS (COMMERCIAL)

APPROVED *HSH* 1-29-38  
DATE



NOMINAL SIZE	DIAMETER		WASHER SECTIONS				CLEARANCE OF NOMINAL BOLT SIZE		ORDNANCE PART NUMBER										
	INSIDE - A -  MIN.	OUTSIDE - B -  MAX.	WIDTH - W -  MIN.	NOMINAL THKNS. - D -  MIN.	INCREASE IN THICKNESS O.D. TO I.D. (T-t)  MAX. MIN.				STANDARD FINISHES		LIMITED STANDARD FINISHES								
					STEEL-(CARBON) CAD. OR ZINC	PHOSPHATE COATED	PLAIN	BLACK ENAMELED	CHROMIUM PLATED	NICKEL PLATED	TIN PLATED	LEAD COATED	BLACK OXIDE		CORROSION RESISTING STEEL				
#2(0.086)	0.088	0.165	0.030	0.015	.0020	.0010	0.011	0.002	192300	192303	192298	192299	192301	192302					582950
#3(0.099)	0.102	0.188	0.035	0.020	.0022	.0011	0.011	0.002	426237	426240	426235	426236	426238	426239					582948
#4(0.112)	0.115	0.202	0.035	0.020	.0022	.0011	0.012	0.003	131180	131195	118871	118875	131185	118880					582949
#5(0.125)	0.128	0.225	0.040	0.025	.0026	.0013	0.012	0.003	426243	426246	426241	426242	426244	426245					582805
#6(0.138)	0.141	0.237	0.040	0.025	.0026	.0013	0.013	0.003	131181	131196	118872	118876	131186	118881					431754
#8(0.164)	0.168	0.280	0.047	0.031	.0030	.0015	0.014	0.004	131182	131197	118869	118877	131187	118882	427231		502280		429067
#10(0.190)	0.194	0.323	0.055	0.040	.0036	.0018	0.015	0.004	131183	131198	118873	118878	131188	118883	427232		502289		582951
#12(0.216)	0.221	0.364	0.062	0.047	.0040	.0020	0.016	0.005	131184	131199	118874	118879	131189	118884			502283		
1/4	0.255	0.489	0.107	0.047	.0068	.0034	0.017	0.005	121637	131200	113114	116164	131190	116171	427233				435862
5/16	0.319	0.575	0.117	0.056	.0074	.0037	0.020	0.006	120379	131201	112723	116165	131191	116172	431927	431821			
3/8	0.382	0.678	0.136	0.070	.0088	.0044	0.023	0.007	120381	131202	110730	116166	131192	114973	432646				
7/16	0.446	0.780	0.154	0.085	.0098	.0049	0.026	0.008	121621	121739	110405	115661	131193	116173					435861
1/2	0.509	0.877	0.170	0.099	.0108	.0054	0.029	0.009	120239	131203	106500	116167	131194	116174					435796
9/16	0.573	0.975	0.186	0.113	.0120	.0060	0.032	0.010	131204	131224	112724	116168	131214	116175					
5/8	0.636	1.082	0.201	0.132	.0132	.0066	0.035	0.011	121625	123167	103334	116169	131215	116176					
11/16	0.700	1.178	0.21						26	131225	115006	118970	131216	118971					
3/4	0.763	1.277	0.23						07	131226	103335	116170	131217	116177					
13/16	0.827	1.375	0.24						06	192309	192304	192305	192307	192308					
7/8	0.890	1.470	0.26						08	131227	103336	112312	131218	116178					
15/16	0.954	1.562	0.27						12	192315	192310	192311	192313	192314					
1	1.017	1.656	0.28						09	131228	117661	118030	131219	118034					
1-1/16	1.081	1.746	0.30						18	192321	192316	192317	192319	192320					
1-1/8	1.144	1.837	0.31						10	131229	118027	118031	131220	118035					
1-3/16	1.208	1.923	0.32						24	192327	192322	192323	192325	192326					
1-1/4	1.271	2.012	0.33						11	131230	117613	117615	131221	117614					
1-5/16	1.335	2.098	0.34						30	192333	192328	192329	192331	192332					
1-3/8	1.398	2.183	0.35						12	131231	118028	118032	131222	118036					
1-7/16	1.462	2.269	0.36						36	192339	192334	192335	192337	192338					
1-1/2	1.525	2.352	0.37						13	131232	118029	118033	131223	118037					
* 11/16	0.700	1.010	0.15								217810								

10

CANCELLED

SUPSD BY MS35338

NOTE: FOR GENERAL SPECIFICATIONS  
MATERIAL: STEEL, CARBON, FS1060  
STEEL, CORROSION RESISTANT  
NOMENCLATURE PATTERN: WASHER, LOCK, SPRING LIGHT  
REFERENCE: AMERICAN STANDARDS ASSOCIATION  
\*SPECIAL SIZE - LIMITED STANDARD.

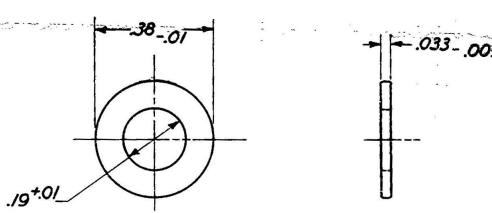
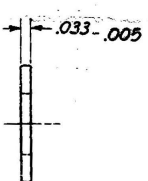
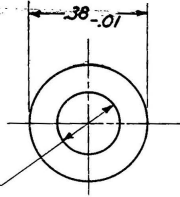
ON QQ-S-633  
S-S-763  
BEEX2, PART NO. 120381

DIMENSIONS IN INCHES.

REVISION ② 8-24-45 ③ 11-8-46 ④ 8-12-48 ⑤ 12-17-48 ⑥ 4-22-49 ⑦ 9-1-54 ⑧ 12-10-54 ⑨ 2-6-61 ⑩ 12-12-67

⑩ CANCELLED  
SUPSD BY MS35338



HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				JUNE 1, 1945	
PROT. FIN. TYPE I OR II SPEC MIL-C-16232		Y.P.	RED.	ROCK.	REVISIONS		
		T.S.	BR.		11	1-28-49	
		EL 2			21	9 JUNE 55	
					33	19 AUG 55	
							
<p><b>WASHER, FOREARM SCREW</b> STEEL, FED SPEC QQ-S-00640: FS 1009</p>		<p><b>DO NOT INSCRIBE PART NO.</b></p>			<p>DRG. PERTAINS TO</p> <p>F7265703 30BARM18A2</p>		
<p>SCALE <math>\frac{4}{1}</math></p>		<p>ORDNANCE DEPT., U.S.A.</p>			<p>ORDNANCE DEPT., U.S.A.</p>		

NOTICE: - THIS DRAWING IS A REPRODUCTION OF THE ORIGINAL DRAWING AND IS NOT TO BE USED FOR CONSTRUCTION OF A PART OR FOR ANY OTHER PURPOSE. THE ORIGINAL DRAWING IS THE ONLY AUTHORITY FOR THE CONSTRUCTION OF A PART. THE REPRODUCTION IS FOR INFORMATION ONLY. THE REPRODUCTION IS NOT TO BE USED FOR CONSTRUCTION OF A PART OR FOR ANY OTHER PURPOSE. THE ORIGINAL DRAWING IS THE ONLY AUTHORITY FOR THE CONSTRUCTION OF A PART.

A 7313164